

Characteristics and Applications:

TWH-41-O is a self-shielded flux-cored wire for building-up or hardfacing on worn workpieces. Its deposit is medium hardness and it is suitable for metal to metal abrasion. The applications include hardfacing of tractor rollers, shaft, mine car wheel, gear and workpiece where medium hardness is required.

Notes on usage:

1. The DC(+) polarity is recommended.
2. Workpiece should be dried in advance to prevent from porosity caused by remnant moisture.
3. Pre-heat and inter-pass temperatures between 150-250 is essential to massive workpieces, heavy cylinders, highly stressed workpieces and high carbon steels.

Typical chemical composition of weld metal (wt%):

C	Mn	Si	Cr	Mo
0.31	2.2	0.60	1.4	0.4

Range of weld metal hardness (on mild steel):

Layer	1st layer	2nd layer	3rd layer
Hardness (HRC)	29-35	34-41	39

LUX CORED WIRES

expressly disclaims any liability
cedures may produce different results

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incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with AWS specification. Other tests and pro
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