

TWH-61P-O

Characteristics and Applications:

TWH-61P-O is a self-shielded flux-cored wire that deposits a primary carbide surfacing alloy with excellent wear resistance and high hardness. The hardness of weld metal can be easily over HRC 60 and can be used on components subjected to severe abrasion with low or moderate impact. It is suitable for the reclamations of coal pulverizer, bucket, dipper teeth and other parts subjected to severe wear.

Notes on usage:

1. The DC(+) polarity is recommended.
2. For the base metal cast iron, low alloy steel and medium carbon steel must preheat above 200 °C is.
3. The weld metal can not be machined by flame cutting except grinding with sand wheel.

Typical chemical composition of weld metal (wt%):

C	Mn	Si	Cr
5.4	0.2	1.3	28.5

Range of weld metal hardness (on mild steel):

Testing Condition	Rockwell's Hardness (HRC)		
	1st layer	2nd layer	3rd layer
Self-shield	50-56	55-61	60-62

Suggested welding parameter (DC<+>):

Parameters	Diameter (mm)	2.8
Volt		25-32
Amps		300-450
Stick out (mm)		50-60

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