

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
Typical value	5.4	0.9	1.0	28.5

Range of weld metal hardness (on mild steel):

	Layer	1st layer	2nd layer	3rd layer
Typical value	Hardness (HRC)	50-56	55-61	60-62

Suggested welding operating range (DC<+>):

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

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