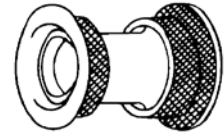


# TH-60

## Characteristics and Applications:

TH-60 deposits a self-hardening martensite structure. High hardness and good slag release can be obtained. It is suitable for shovel tooth, bulldozer blades, crane wheels and buckets.



Drive wheel

## Notes on usage:

1. Bake the electrodes at 300~350°C for 60 minutes before using.
2. Clean up the contaminations on the base metal.
3. Use back-step method to prevent arc starting from blowholes and stay for 3-5 seconds before every end-up.
4. Preheat the plates and keep the interpass temperature above 150°C to prevent cracking.
5. Using low hydrogen electrode for buffer layer on difficult-to-weld steels, particular at multi-pass weldments.
6. Maintain short arc length. Moving range should be controlled within 2.5 times of the wire's dia when you are welding with weave method.

## Typical chemical composition of weld metal (wt%):

C	Mn	Si	Cr
0.35	1.2	0.30	2.8

## Typical hardness of weld metal:

Testing Condition		Vicker's Hardness (HV)	Rockwell's Hardness (HRC)	Shore's Hardness (HS)
As	Interpass temp. 150°C	490	48	64
Welded	Cont. Build Up	420	43	57
Water Quenching at 600°C		370	38	52

## Welding position:



## Sizes and recommended current range (AC or DC <+>):

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	350	450
Current Range	80-130	120-180	160-220

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