

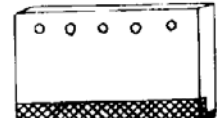
TH-80R

Characteristics and Applications:

TH-80R deposits a self-hardening martensite structure. It features high hardness and good slag removability. It is suitable for pump impeller, cutter blades, agitator propeller, sugar cane hammers

Notes on usage:

1. Dry the electrodes at 80-120°C for 60 minutes before using.
2. Clean up the contaminations on the steel.
3. Take the back-step method to prevent blowhole at the arc starting.
4. Pre-heat the plates and keep the inter-pass temperature above 200°C to prevent cracking.
5. Use low hydrogen electrode for buffer layer on difficult-to-weld steels.



Bull dozing Plate

Typical chemical composition of weld metal (wt%):

C	Mn	Si	Cr	Mo
0.4	0.40	0.45	4.5	0.004

Typical hardness of weld metal:

Testing Condition		Vicker's Hardness (HV)		Rockwell's Hardness (HRC)		Shore's Hardness (HS)	
Interpass temp. 150°C		620		57		75	
Cont. Build Up		590		55		72	
As Welded	Temp(°C)	200	300	400	500	600	700
	Hardness(HV)	510	470	420	410	200	90

Welding position:



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

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	450	450
Amps	80-120	120-170	160-210

* The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and TienTai Electrode Co., Ltd. expressly disclaims any liability incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with AWS specification. Other tests and procedures may produce different results. No data is to be construed as recommendation for any welding condition or technique not controlled by TienTai Electrode Co., Ltd.