

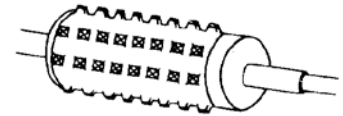
# TH-90

## Characteristics and Applications:

TH-90 deposits a self-hardening martensite structure which contains carbide-forming elements such as Cr, B. Machining is difficult in as welded condition. The weld metal provides high hardness and good abrasion resistance accompanied with medium impact. It is suitable for earthwork, sand pump and bucket.

## Notes on usage:

1. Dry the electrodes at 300-350°C for 60 minutes before using.
2. Keep the interpass temperature above 300°C and above, PWHT at about 500-600°C.
3. Use low hydrogen type electrode for buffer welding.



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

C	Mn	Si	Cr	Special elements
0.60	1.20	0.9	6.5	1.2~2.0

## Typical hardness of weld metal:

Testing Condition		Vicker's Hardness (HV)	Rockwell's Hardness (HRC)	Shore's Hardness (HS)
As Welded	Interpass temp. 100°C	740	60	85
	Cont. Build Up	700	60	82

## 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

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