

TWH-58-G

Characteristics and Applications:

TWH-58-G is a flux-cored wire for CO₂ welding with the properties of stable arc, smooth bead appearance and low sensitivity of blow-hole. It is able to obtain the weld metal with good wear resistance under wide range of welding parameter owing to its high hardness of weld metal and low penetration. It is suitable for hardfacing of bulldozer blade, bucket lip, tipper teeth, the parts of impeller subjected to severe soil abrasion.

Notes on usage:

1. Pre-heat and inter-pass temperature must be over 300 °C and slowly cooled to room temperature after welding.
2. Keep the product dry, while it is stored or delivered.

Typical chemical composition (wt%):

C	Mn	Si	Cr	W
0.41	0.5	2.8	7.5	0.6

Typical weld metal hardness (on mild steel):

Layer	5th layer
Hardness (HRC)	57-59

Suggested welding parameter (DC<+>):

Diameter (mm)	1.2mm	1.6mm
Parameters		
Voltage (Volt)	25-34	25-34
Current (Amp)	150-280	200-350
Flow rate of shield gas (l/min.)	CO ₂ ,20-25	

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