

# TWH-67-O

## Characteristics and Applications:

TWH-67-O, a self-shielded flux-cored wire, develops a ledeburitic structure with a great amount of embedded Chromium Carbides and super-hard metalborides. The alloy is specifically designed for extreme abrasive wear at high temperatures. The deposits can't be flame out, heat-treated, machined or forged except grinding.

It is used for blast furnace bell, sugar cane industry, bucket teeth and coke oven screen etc.

## Notes on usage:

1. For hardfacing the high-carbon steel or the low-alloy steel, the welding consumables of the austenite stainless steel could be welded as buffer layer.
2. Do not weld too many layers, if you want to avoid crack. For welding many layers, you should use the bead of rib or waffle pattern.

## Typical chemical composition (wt%):

C	Mn	Si	B	Cr
5.1	0.5	0.8	1.5	37

## Typical weld metal hardness (on mild steel):

Hardness (HRC)	63-67
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## Suggested welding parameter (DC<+>):

Parameters	Diameter (mm)	2.8	3.2
	Voltage (Volt)		26-32
Current (Amp)		250-450	300-650
Stick out (mm)		50-60	50-60

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