

# TWS-420Mo-G

## Characteristics and Applications:

TWS-420Mo-G is a flux-cored wire for CO<sub>2</sub> welding, which weld metal contains 13%Cr-1%Mo. It is suitable for application requiring resistance to soil abrasion and corrosion wear such as hardfacing of shovel, press model, the parts of bulldozer, valve seat, agitator propeller, turbine fan, conveyer screw.

## Notes on usage:

1. Pre-heat and inter-pass temperature must be over 200 °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    | Si  | Mn  | Cr   | Mo  |
|------|-----|-----|------|-----|
| 0.30 | 0.4 | 0.4 | 12.7 | 0.8 |

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

| Layer          | 5th Layer |
|----------------|-----------|
| Hardness (HRC) | 49-53     |

## Suggested welding parameter (DC<+>):

### Stick out: 15-20(mm)

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

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