

TWH-58-G

特性與用途:

TWH-58-G 為 CO₂ 銲接用包藥銲線，其電弧穩定、銲道外觀良好、耐氣孔性良好。由於其熔金具高硬度且滲透淺，所以在相當廣之銲接條件下都可獲得耐磨耗性良好之熔金。其適用於推土機鏟刀、吊桶唇、傾倒車牙、承受嚴重土壤磨擦之推進器部件之硬面銲接。

注意事項:

(1) 預熱與層間溫度需超過 300°C，銲接後徐冷至室溫。

銲道化學成份之一例 (wt%)

	C	Mn	Si	Cr	W
例值	0.41	0.5	2.8	7.5	0.6

銲道硬度值之一例 (銲在軟鋼上)

層數	第 5 層
硬度 (HRC)	57-59

銲接參數建議 DC(+)

伸出長度：15-20(mm)

線 徑(mm)	1.2	1.6
銲接參數		
電壓 (Volt)	25-34	25-34
電流 (Amp)	150-280	200-350
保護氣體流量 (l/min)	CO ₂ ,20-25	

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