

TH-950HCR

Characteristics and Applications:

TH-950HCR deposits the weld metal (30%Cr, 5%C) consists of primary carbides in a matrix of austenite-carbide eutectic. It can be used on carbon, low alloy, stainless steel, and manganese. The weld metal exhibits high hardness, good corrosion resistance, resistance to severe earth abrasion. It is suitable for crusher rolls, plates and Jaws, sleeves, cement mill part, conveyor screw, blades.



Agitator blade

Notes on usage:

1. Dry the electrodes at 300-350°C for 30-60 minutes before using.
2. Clean up the contaminations on the base metal to avoid porosity and crack.
3. Use back-step method and stay for 3-5 seconds before every end-up to prevent arc starting from blowholes.
4. Maintain short arc length. Moving range should be controlled within 2.5 times of the wire's dia when you are welding with weave method.
5. Deposits should be limited to 2 layers.

Typical chemical composition of weld metal (wt%):

	C	Mn	Si	Cr
Typical value	5.5	2.2	0.32	30.0

Typical hardness of weld metal:

Testing Condition (As Welded)	Vicker's Hardness (HV)	Rockwell's Hardness (HRC)	Shore's Hardness (HS)
Interpass temp. 150°C	700	60	81
Continuous welding	680	59	80

Welding position:



Sizes and recommended current range (AC or DC+):

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	350	450
Amps	90-140	140-190	190-250

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