

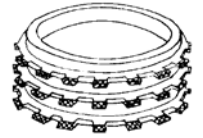
TH-950B

Characteristics and Applications:

TH-950B deposits the weld metal of high Cr martensite structure containing carbides. The weld metal has high hardness, resistance to earth abrasion. Less resistance to abrasion accompanied by heavy impact. It is suitable for various rollers and crusher mantles.

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 to prevent arc starting from blowholes and stay for 3-5 seconds before every end-up.
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. Preheat over 400°C in order to relieve crack.



Mill roller wheel

Typical chemical composition of weld metal (wt%):

	C	Mn	Si	Cr	Mo
Typical value	5.5	3.0	1.4	29.2	0.58

Typical hardness of weld metal:

Testing Condition		Vicker's Hardness (HV)	Rockwell's Hardness (HRC)	Shore's Hardness (HS)
As Welded	Interpass temp. 150°C	740	62	85
	Cont. Build Up	700	60	82

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	190-240

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