TH-50N-4

Characteristics and Applications:

TH-50N-4 deposits the weld metal of 12%Cr martensite structure which contains the elements such as Ni, Mo. The weld metal provides stable hardness, better corrosion resistance, heat resistance and crack resistance than TH-50 at high temperature. It is suitable for the welding of dies, blades, seat rings and agitator propellers.

Notes on usage:

1. Be sure to clean up the contaminations on the base metal to avoid porosity and crack.
2. Dry the electrodes at 250-300℃ for 60 minutes before using.
3. Preheat the plates at 150℃
4. Use back-step method to prevent arc starting from blowholes and stay for 3-5 seconds before every end-up.
5. 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.

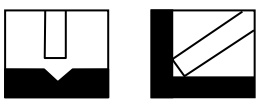
Typical chemical composition of weld metal (wt%):

	C	Mn	Si	Cr	Ni	Mo
Typical value	0.15	0.25	0.65	11.00	3.5	0.75

Typical hardness of weld metal:

Testing Condition	Vicker's Hardness (HV)	Rockwell's Hardness (HRC)	Shore's Hardness (HS)
Interpass temp. 150℃ (As Welded)	510	50	66

Welding position:



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

Diameter (mm)	3.2	4.0	4.8
Length (mm)	350	350	350
Amps	80-130	120-180	160-220

COVERED ELECTRODES

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