

TWS-420Mo-G

Characteristics and Applications:

TWS-420Mo-G is a flux-cored wire for CO₂ 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	Mn	Si	Cr	Mo
Typical value	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 ₂ ,20-25	

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