

TWH-68NM-G

Characteristics and Applications:

TWH-68NM-G is a metal-cored wire for CO₂ welding with the properties of stable arc and little slag. With deposit efficiency around 93%, the weld metal contains carbide forming elements such as Cr, Mo, Nb and offers excellent resistance to severe abrasion wear.

It is suitable for hardfacing of hopper liner for steel mill, roll crusher for crushing raw cement material, roll mill for crushing coal and table liner.

Notes on usage:

1. For hardfacing high-carbon steel or low-alloy steel, the welding consumables of the austenite stainless steel could be welded as buffer layer.
2. Do not weld too many layers, if you want to avoid crack. For welding many layers, you should use the bead of rib or waffle pattern.
3. Keep the product dry, while it is stored or delivered.

Typical chemical composition (wt%):

	C	Si	Mn	Cr	Mo	Nb
Typical value	6.5	2.2	0.3	23.2	1.8	3.5

Typical weld metal hardness (on mild steel):

Layer	5th Layer
Hardness (HRC)	≥67

Suggested welding parameter (DC<+>):

Stick out: 15-20(mm)

Parameters	Diameter (mm)	
	1.6	2.0
Voltage (Volt)	25-34	23-34
Current (Amp)	200-350	300-450
Flow rate of shield gas (l/min.)	CO ₂ ,20-25	

* The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and TienTai Electrode Co., Ltd. expressly disclaims any liability incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with AWS specification. Other tests and procedures may produce different results. No data is to be construed as recommendation for any welding condition or technique not controlled by TienTai Electrode Co., Ltd.