TWH-65W-G

Characteristics and Applications:

TWH-65W-G is a metal-cored wire for CO_2 welding with the properties of stable arc and little slag. With deposit efficiency of 93%, the weld metal contains carbide forming elements such as Cr, Nb, Mo, W, V which offer excellent resistance to severe abrasion wear.

It is designed 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 the high-carbon steel or the low-alloy steel, the welding consumables of the austenitic 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	W	Mo	V	Nb
Typical value	5.2	1.9	0.5	21.5	3.7	0.6	0.5	3.0

Typical weld metal hardness (on mild steel):

Layer	5th layer
Hardness (HRC)	66-69

Suggested welding parameter (DC<+>):

Stick out: 15-20(mm)

Parameters \ Diameter (mm)	1.2	1.6	2.0
Voltage (Volt)	25-34	25-34	23-34
Current (Amp)	150-280	200-350	300-450
Flow rate of shield gas (l/min.)	CO_2,20-25		

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