

TWH-65-O

Characteristics and Applications:

TWH-65-O is a self-shielded flux cored wire to produce weld metal which is resistant to extreme abrasive wear even at high temperature. The deposits can not be flame cut, heat-treated, machined or forged.

It is used for blast furnace bell, sugar cane industry, bucket teeth and coke oven screen etc.

Notes on usage:

1. The recommended deposit is two layers.

Typical chemical composition of weld metal (wt%):

	C	Mn	Si	Cr	Mo	W	Nb	V
Typical value	5.1	0.6	0.9	22.5	5.0	1.2	5.5	1.1

Range of weld metal hardness (HRC):

Room temp.	63-65
600°C	50-52

Suggested welding parameter (DC<+>) :

Parameters	Diameter (mm)	2.8	3.2
	Volt	25-32	28-36
Amps	300-450	300-650	
Stick out (mm)	50-60	50-70	

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