

TWH-62-G

Characteristics and Applications:

TWH-62-G is a flux-cored wire for CO₂ welding with the properties of stable arc, smooth bead appearance and low sensitivity of blow-hole. It provides the weld metal with good resistance to wear under wide range of welding parameter owing to its high hardness of weld metal and low penetration.

It is suitable for hardfacing of bulldozer blade, bucket lip, tipper teeth, the parts of impeller subjected to severe soil abrasion.

Notes on usage:

1. The pre-heat and inter-pass temperature must be over 300°C and be slowly cooled to room temperature after welding.
2. Keep the product dry, while it is stored or delivered.

Typical chemical composition (wt%):

	C	Si	Mn	Cr	B
Typical value	0.75	0.70	0.9	7.9	0.5

Typical weld metal hardness (on mild steel):

Layer	5th layer
Hardness (HRC)	61-64

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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