

# TWH-41-O

## Characteristics and Applications:

TWH-41-O is a self-shielded flux-cored wire for building-up or hardfacing on worn workpieces. Its deposit is medium hardness and it is suitable for metal to metal abrasion. The applications include hardfacing of tractor rollers, shaft, mine car wheel, gear and workpiece where medium hardness is required.

## Notes on usage:

1. The DC(+) polarity is recommended.
2. Workpiece should be dried in advance to prevent from porosity caused by remnant moisture.
3. Pre-heat and inter-pass temperatures between 150-250°C is essential to massive workpieces, heavy cylinders, highly stressed workpieces and high carbon steels.

## Typical chemical composition of weld metal (wt%):

	C	Mn	Si	Cr	Mo
Typical value	0.31	2.2	0.6	1.4	0.4

## Range of weld metal hardness (on mild steel):

Layer	1st layer	2nd layer	3rd layer
Hardness (HRC)	29-35	34-41	39-43

## Suggested welding parameter (DC<+>) :

Parameters	Diameter (mm)	2.4	2.8
	Volt		25-32
Amps		250-400	300-450
Stick out (mm)		50-60	50-60

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