

# TWH-34-O

## Characteristics and Applications:

TWH-34-O is a self-shielded flux-cored wire for building up or hardfacing on worn workpieces. The hardness of the deposited metal is about HRC 34 which can be machined by carbide tools. It is designed for hardfacing or build-up or repair of tractor roll, shaft, mine car wheel, gear and workpieces which medium hardness is required.

## Notes on usage:

1. The DC(+) polarity is recommended.
2. The pre-heat and inter-pass temperatures should be between 150-250°C for massive workpieces.
3. Dry the workpiece in advance to prevent from porosity caused by remnant moisture.

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

	C	Mn	Si	Cr
Typical value	0.16	2.0	0.5	1.2

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

Layer	1st layer	2nd layer	3rd layer
Hardness (HRC)	23-29	27-32	30-34

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

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

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