

TWH-12-S

/TF-81

Characteristics and Applications:

TWH-12-S is a submerged arc flux-cored wire to provide a modified H12 tool steel deposit which retains hardness at high temperatures. TWH-12-S flux-cored wire is used with TF-81, a neutral flux, for submerged arc welding applications. The combination is suitable for work rolls, pinch rolls and surfaces subjected to sliding metal/metal wear.

Notes on usage:

1. The DC(+) polarity is recommended.
2. The workpiece should be free of moisture to prevent porosity and enhance the interfacial bonding between parent steel and weld metal.
3. To prevent weld crack, the pre-heat and inter-pass temperatures should be between 204-316°C for massive workpieces, heavy cylinders and highly stressed workpieces..

Typical chemical composition (wt%):

	C	Mn	Si	Cr	Mo	V	W
Typical value	0.23	1.6	0.6	6.1	1.3	0.2	1.2

Typical weld metal hardness (on mild steel) :

Hardness (HRC)	47-53
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Suggested welding parameter DC(<+>):

Parameters	Diameter (mm)
	3.2
Volt	25-32
Amps	300-450
Stick out(mm)	30-40

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