

# TWH-62-G

## 特性與用途:

TWH-62-G 為 CO<sub>2</sub> 銲接硬面包藥銲線，其電弧穩定、銲道外觀良好、耐氣孔性良好。由於其熔金具高硬度且滲透淺，所以在相當廣之銲接條件下都可獲得耐磨耗性良好之熔金。其適用於推土機鏟刀、吊桶唇、傾倒車牙、承受嚴重土壤磨擦之推進器部件之硬面銲接。

## 注意事項:

1. 預熱與層間溫度需超過 300°C，銲接後徐冷至室溫。

## 銲道化學成份之一例 (wt%)

	C	Mn	Si	Cr	B
例值	0.75	0.9	0.70	7.9	0.5

## 銲道硬度值之一例 (銲在軟鋼上)

層數	第 5 層
硬度 (HRC)	61-64

## 銲接參數建議 DC(+)

伸出長度：15-20(mm)

線徑(mm)	1.2	1.6
銲接參數		
電壓 (Volt)	25-34	25-34
電流 (Amp)	150-280	200-350
保護氣體流量 (l/min)	CO <sub>2</sub> ,20-25	

\* The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and TienTai Electrode Co., Ltd. expressly disclaims any liability incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with AWS specification. Other tests and procedures may produce different results. No data is to be construed as recommendation for any welding condition or technique not controlled by TienTai Electrode Co., Ltd.