

TWH-67-O

特性與用途:

為含碳化鉻及硼化物析出之自遮護包藥銲線，銲道通常有應力釋放裂紋產生，銲後熔金硬度極高，無法以機械加工，只能使用砂輪研磨加工。適用場合為高磨耗低衝擊如煤滾輪、鬼齒、受齒、鼓風煤罩、研碎機零件等硬面修補。

注意事項:

- (1)對於高碳鋼或低合金鋼材之硬面銲接，可使用沃斯田鐵不銹鋼銲材覆面。
- (2)建議不要銲太多層以免龜裂。如果必須多層銲接時，可銲成格子或肋骨狀。

銲道化學成份之一例 (wt%)

	C	Mn	Si	B	Cr
例值	5.1	0.5	0.8	1.5	37

銲道硬度值之一例 (軟鋼母材)

層數	第 4 層
硬度 (HRC)	63-67

銲接參數建議 DC(+)

線 徑(mm)	2.8	3.2
銲接參數		
電壓 (Volt)	26-32	28-36
電流 (Amp)	250-450	300-650
伸出長度(mm)	50-60	50-60

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