

TH-950HN

Characteristics and Applications:

TH-950HN deposits the weld metal (22%Cr) of high C-high Cr structure containing complex carbides. Oxidization resistance, hardness at high temperature and resistance to earth abrasion at high temperature are excellent. It is suitable for agitator propellers, pulverizers blades, and pump impellers.

Notes on usage:

1. Dry the electrodes at 300-350°C for 30-60 minutes before using.
2. Clean up the contaminations on the base metal to avoid porosity and crack.
3. Use back-step method to prevent arc starting from blowholes and hold for 3-5 seconds at every end-up.
4. Maintain short arc length. Moving range should be controlled within 2.5 times of the wire's dia when you are welding with weave method.
5. Preheat above 250°C in order to prevent from stress-relief crack.
6. While welding many layers, the bead of rib or waffle pattern should be applied, its can prevent form deposited metal come off.

Typical chemical composition of weld metal (wt%):

	C	Mn	Si	Cr	Nb	Mo	V	W
Typical value	5.0	1.6	1.5	23.2	4.0	5.5	1.82	2.2

Typical hardness of weld metal:

Rockwell's Hardness (HRC)		Vicker's Hardness (Hv)			
Interpass temp. 150°C	Continue. Build Up	300°C	400°C	500°C	600°C
64	61	720	640	580	460

Welding position:



Sizes and recommended current range (AC or DC <+>):

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	350	450
Amps	90-140	140-190	190-240

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