

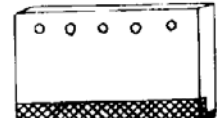
# TH-80R

## Characteristics and Applications:

TH-80R deposits a self-hardening martensite structure. It features high hardness and good slag removability. It is suitable for pump impeller, cutter blades, agitator propeller, sugar cane hammers

## Notes on usage:

1. Dry the electrodes at 80-120°C for 60 minutes before using.
2. Clean up the contaminations on the steel.
3. Take the back-step method to prevent blowhole at the arc starting.
4. Pre-heat the plates and keep the inter-pass temperature above 200°C to prevent cracking.
5. Use low hydrogen electrode for buffer layer on difficult-to-weld steels.



Bull dozing Plate

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

	C	Mn	Si	Cr	Mo
Typical value	0.4	0.40	0.45	4.5	0.004

## Typical hardness of weld metal:

Testing Condition		Vicker's Hardness (HV)		Rockwell's Hardness (HRC)		Shore's Hardness (HS)	
Interpass temp. 150°C		620		57		75	
Cont. Build Up		590		55		72	
As Welded	Temp(°C)	200	300	400	500	600	700
	Hardness(HV)	510	470	420	410	200	90

## Welding position:



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

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	450	450
Amps	80-120	120-170	160-210

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