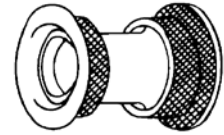


TH-60

Characteristics and Applications:

TH-60 deposits a self-hardening martensite structure. High hardness and good slag release can be obtained. It is suitable for shovel tooth, bulldozer blades, crane wheels and buckets.



Drive wheel

Notes on usage:

1. Bake the electrodes at 300~350°C for 60 minutes before using.
2. Clean up the contaminations on the base metal.
3. Use back-step method to prevent arc starting from blowholes and stay for 3-5 seconds before every end-up.
4. Preheat the plates and keep the interpass temperature above 150°C to prevent cracking.
5. Using low hydrogen electrode for buffer layer on difficult-to-weld steels, particular at multi-pass weldments.
6. 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.

Typical chemical composition of weld metal (wt%):

	C	Mn	Si	Cr
Typical value	0.35	1.2	0.30	2.80

Typical hardness of weld metal:

Testing Condition		Vicker's Hardness (HV)	Rockwell's Hardness (HRC)	Shore's Hardness (HS)
As	Interpass temp. 150°C	490	48	64
Welded	Cont. Build Up	420	43	57
Water Quenching at 600°C		370	38	52

Welding position:



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

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	350	450
Current Range	80-130	120-180	160-220

* 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.