

TWH-65-O

特性與用途：

為高碳化鉻析出及含高溫合金元素之自遮護包藥銲線，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輓輪、鬼齒、鼓風煤罩、研碎機零件等硬面修補。

注意事項：

- (1) 先前工件殘留的舊硬面層可以破精棒剷除。
- (2) 銲後熔金請勿作熱處理。

銲道化學成份之一例(wt%)：

C	Mn	Si	Cr	Mo	W	Nb	V
5.1	0.6	0.9	22.5	5.0	1.2	5.5	1.1

銲道硬度值範圍之一例：(HRC)

室溫硬度	63-65
高溫硬度 600°C	50-52

銲接參數建議：(DC+)

線徑(mm)	2.8	3.2
銲接參數		
電壓(Volt)	25-32	28-36
電流(Amp)	300-450	300-650
伸出長度(mm)	50-60	50-70

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