

TWS-420Mo-G

特性與用途:

TWS-420Mo-G 為 CO₂ 銲接用包藥銲線，熔金含 13%Cr-1%Mo。其適用於耐土壤磨擦、耐腐蝕磨耗之應用，如挖土鏟、衝模、推土機之部件、閥座、攪拌螺旋槳、渦輪葉片、輸送螺旋之硬面銲接。

注意事項:

(1)預熱與層間溫度需超過 200°C，銲後徐冷至室溫。

銲道化學成份之一例 (wt%)

C	Si	Mn	Cr	Mo
0.30	0.4	0.4	12.7	0.8

銲道硬度值之一例 (銲在軟鋼上)

層數	第 5 層
硬度 (HRC)	49-53

銲接參數建議 DC(+)

伸出長度：15-20(mm)

線 徑(mm)	1.2	1.6
銲接參數		
電壓 (Volt)	25-34	25-34
電流 (Amp)	150-280	200-350
保護氣體流量 (l/min.)	CO ₂ ,20-25	

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