

TRU TUF CB

Welding Procedures:

- Weldable structural steel back plate
- Chokblocks welded to slightly convex or concave surfaces by bending mild steel backing plate
- On low Alloy surfaces – Low Hydrogen E7016 or E7018 rod or E70T-5 wire. Keep interpass temperatures below 500°F
- On Manganese surfaces – E309-16 Stainless Steel rod. Keep Interpass temperatures below 200°F
- Parent metal should only be warm to hand 6" from the welds
- Continuous weld beads should not be used
- Recommended maximum run length is 2"-2.75" to minimize heat input
- Ensure welding does not come closer than 0.08" from joint line between chrome white iron and backing plate
- Best results – Tru Tuf CB product should be clamped and tack-welded into position prior to final welding

Preheat Instructions (for Parent metal surfaces Only)

- Caution – *Do NOT preheat Tru Tuf CB product*
- Parent metal surface clean and flat as possible
- Working in temperatures above 40°F:
Preheat heavy sections (1.5" or greater) to 200°F
No post heat required
- Working in temperatures at or below 40°F:
Preheat to 350-400°F
- Do not preheat if welding on Manganese surfaces
Regardless of air temperature

For more Information please contact a
Tru Steel Metals Consultant

