



Techniwear 50

Metal-Cored, Open-Arc, or Gas Shielded Hardfacing Filler Metal

Features

- Metal-cored, open arc, or gas shielded wire
- Deposits are slag free
- For use in applications involving high impact and abrasion.
- May be used on a variety of steels including austenitic manganese steels
- Medium Hardness chromium carbide hardfacing wire with good resistance to abrasion and impact
- Open-arc wire for convenience and use in the field or shop
- Bonds well with carbon, low alloy, and manganese steels

Applications

- Final overlay on crusher jaws
- Impact breaker bars
- Cone and roll shells
- Pulverizing hammers
- Hammer mill hammers

Diameters & Packages

Diameter	25 lb	55 lb
0.045"	✓	
0.062" (1/16")	✓	
0.109" (7/64")		✓

Technical Specifications

- **Average Hardness:** 47-52 HRC
- **Deposit Thickness:** 3-5 layers
- **Current:** DC Electrode Positive
- If a gas cover is used, Argon/CO2 or 100% CO2 is recommended.
- Cannot be flame-cut

Recommended Weld Parameters:

Diameter	Volts	Amps	Stick Out
0.045"	15-26	100-250	¾"-1"
0.062" (1/16")	20-25	160-300	1"-1 ¼"
0.109" (7/64")	24-30	250-450	1"-1 ½"

- **Welding Procedure:** When welding out of position, use the lower range of amperages and voltages. In addition, a gas cover may be useful, especially when using a constant current power source and voltage sensing feeder.