



TECHNIWEAR 25[®]

Data Sheet

Description:

Low alloy buildup wire with very good compressive strength and resistance to plastic deformation. An ideal base for subsequent overlay with a more wear resistant alloy. Also good when an easily machined "as welded" deposit is required. Use on carbon and low alloy steels.

Specifications

Wire Type: Metal-cored, Gas-shielded
Deposits are slag-free

Weld Deposit Properties:

Hardness: 21 - 25 Rc
Maximum Deposit Thickness: Unlimited
Deposits can be flame cut
Deposits are fully machinable

Welding Parameters - Use DC Reverse Polarity

	SHORT-ARC		SPRAY-ARC		PULSED SPRAY ARC WELDING		
	.045	1/16	.045	1/16	Use 98/2 Argon/Oxygen with 120pps		
					.045	1/16	
Amps	90-200	150-220	250-325	300-375	Current	200 220 250	250 275 300
Volts	15-21	18-21	27-30	27-30	Peak Amps	350 375 425	350 375 400
Gas	Ar/CO2	Ar/CO2	Ar/Ox	Ar/Ox	Volts	24 25 26	24 25 26
CFH	25-30	25-30	40-45	40-45	CFH	40-45	40-45
Stick-out	1/2"	3/4"	5/8"	3/4"	Stick-out	5/8"	3/4"

When welding out-of-position, use the lower ranges of voltages and amperages: 16 - 19 volts and 100 - 150 amps.

Packaging

Diameter .045"(1.2mm) 1/16"(1.6mm)
25 Lb. Spools Standard Standard