



TECHNIWEAR 63M[®]

Data Sheet

Description:

Techniwear 63M is a multi-carbide open arc wire used to yield a deposit of primary chromium carbides and secondary columbium carbides in a martensitic matrix. Due to its unique deposit chemistry, the typical wear life will increase approximately 33% over standard chromium carbide alloys. The weld deposit gives high abrasion resistance with moderate impact. Techniwear 63M is designed for single and double pass overlay applications and the “as welded” deposit will stress relief cross crack. Techniwear 63M maintains its hardness and wear resistance into 1200°- 1400°F range.

Specifications:

Wire Type: Self Shielded open-arc metal cored wire
Deposits are slag-free

Weld Deposit Properties:

Average Hardness: 60 - 63 Rc
Deposit Thickness: 1 to 2 layers
Deposits cannot be flame cut
Deposits will check-crack to relieve stresses

Typical Chemistry (All Weld Metal):

Carbon -5.40	Manganese -1.20	Silicon - 1.20	Chromium - 23.00
Columbium - 7.00	Others - 2.00	Iron - Bal	

Applications

Clad wear plate	Slurry pipe
Grinding rolls	Table segments
Aggregate screens	Fan blades

Welding Parameters - DC Reverse Polarity

Diameter	1/16”(1.6mm)	7/64”(2.8mm)	1/8” (3.2mm)
Current <i>amps</i>	200-270	350-450	450-650
Voltage (DCRP) <i>volts</i>	24-28	27-31	29-34
Stickout <i>inch (mm)</i>	1”+- ¼ ”(25-35mm)	1 ½ “(40mm)	1 ½” (40mm)

Packaging

Diameter	1/16” (1.6mm)	7/64” (2.8mm)	1/8” (3.2mm)
25# Spools	Standard	NA	NA
60# Coils	Available	Standard	Standard
250# / 500# Drums	NA	Standard	Standard