



TECHNIWEAR 67M[®]

Data Sheet

Description:

Techniwear 67M is a high hardness multi-carbide hardfacing alloy that resists severe abrasion, including high stress grinding, low stress scratching and gouging abrasion. It maintains its hardness and wear resistance up to 1400°F (760°C). The chemistry is highly tolerant of dilution. One layer will easily outwear two layers of ordinary chrome carbides and in some applications the wear is equal to tungsten carbide.

Specifications:

Wire Type: Metal-cored, open arc or gas-shielded (CO₂). Deposits are slag-free.
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Weld Deposit Properties:

Average Hardness: 63 - 67 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

Agricultural implements	Sinter plant parts	Blast furnace charging equipment
Cement mill parts	Coke pusher shoes	Brick making equipment
Coke crusher segments	Conveyor screws	Cereal grinding equipment
Tong bits	Slag ladles	Mixer paddles
Ash fans	Wear bars	Solid waste shredder parts
Wear plates		

Welding Parameters - DC Reverse Polarity

Diameter	.045 (1.2mm)	1/16"(1.6mm)
Current <i>amps</i>	100-225	200-270
Voltage (DCRP) <i>volts</i>	15-26	21-28
Stickout <i>inch (mm)</i>	3/4" - 1" (18-25mm)	1" - 1 1/2" (25-38mm)

** While all sizes of Techniwear 67M will easily operate with or without a gas cover, you may find applications for .045 and 1/16 for which you prefer a shielding gas. If a gas cover is used, Argon/CO₂ or 100% CO₂ is recommended. This will cause amperages to go up by about 10% and the stick-out should be shortened. 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.**

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.