TECHNIWEAR 50®

Data Sheet

Description:

A chromium carbide hardfacing alloy that produces a controlled microstructure of specially sized carbides in a very tough matrix. For applications involving high impact combined with abrasion. Weld metal is tougher than conventional chromium carbide alloys with fewer stress relieving check-cracks.

Specifications

Wire Type: Metal-cored, open-arc or gas-shielded
Deposits are slag-free

Alloy Content: Carbon, Chromium, Manganese, Silicon

Weld Deposit Properties:

Hardness: 45 - 50 Rc
Deposit Thickness: 3-5 layers
Deposits cannot be flame cut

Welding Parameters – DC Reverse or Straight Polarity

Diameter	**.045" (1.2mm)**	**1/16" (1.6mm)**	**7/64" (2.8mm)**
Current *amps*	100-250	160-300	250-450
Voltage (DCRP) *volts*	15-26	20-25	24-30
Stickout *inch (mm)*	3/4"-1"(18-25mm)	1"-1 "(25-35mm)	1 "(40mm)
Gas Flow *cfh (l/hr*)	NA	NA	NA

While all sizes of Techniwear 50 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.

Packaging

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