



Techniwear 31 Electrode

Description:

Techniwear 31 is a hardfacing electrode with easy slag removal and excellent welder appeal. It has a moderate alloy content, providing a balanced performance on abrasion resistance and impact. Deposits are not machinable or forgeable. **Techniwear 31** bonds well with carbon, low alloy, and manganese steels. Deposits are slightly magnetic on carbon and low alloy steels, but not on manganese steels, and will develop cross checks.

Specifications:

Abrasion Resistance	Good
Impact Resistance.....	Moderate
On Carbon Steel.....	50-55 Rc
On Manganese Steel.....	45-50 Rc
Surface Cross Checks	Yes
Machinability	No
Deposit Layers	Up to 2

Applications:

Crusher rolls	Compactors
Impact breaker bars	Dozer and grader blades
Dredge pump shells and Impellers	Grader end bits
Excavator parts	Post hole augers
Mining	Wear areas on clamshell
Earthmoving and construction equipment	Dragline and shovel buckets
Bucket lips and teeth	

Welding Procedure: AC or DC Straight or Reverse:

Diameter:	1/8 (3.2mm)	5/32 (4.0mm)	3/16 (4.8mm)
Amperages:	120-150	140-180	180-250

** Due to lower dilution, DC straight polarity will produce a higher first pass hardness and is also ideal for thin sections. Remove all damaged or fatigued metal. Preheating is generally not required. However, for high carbon or alloy steels and cast iron, a preheat of approximately 400°F (204°C) is recommended. Maintain a short to medium arc using a weave technique. Remove slag. **

Notice: The results reported are based upon testing of the product under controlled laboratory conditions. 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.