



## TECHNIWEAR 40<sup>®</sup>

Medium hardness build-up wire with excellent compressive strength. Recommended for applications where weld deposits must provide good metal-to-metal wear resistance, but still be machinable "as welded". Use on carbon and low alloy steels.

### Specifications

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

### Weld Deposit Properties:

Hardness: 33 - 38 Rc  
Maximum Deposit Thickness: Unlimited  
Deposits can be flame cut  
Machinable with carbide tools

### Applications

Machine components	Steel mill parts
Keyways	Carbon steel railroad track components
Undercarriage	Parts of earth moving and mining equipment
Gear teeth	

### Welding Parameters - Use DC Reverse Polarity

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

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

*Also available as a flux-cored, open-arc wire*