



TECHNIWEAR 61[®]

A premium chromium carbide alloy that has a high volume fraction of carbides dispersed in a hard matrix. For applications involving high abrasion and mild or moderate impact. Deposit polish in service and are heat resistant to 1000°F (531°C). Use on carbon and low alloy steels.

Specifications

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

Weld Deposit Properties:

Average Hardness: 58 - 62 Rc per ASTM E.18.0 & Mil 2540.0
Deposit Thickness: 1 to 2 layers
Deposits cannot be flame cut
Deposits will check-crack to relieve stresses

Applications

Scrapper blades	Auger flights
Road ripper teeth	Screw conveyors
Bucket teeth bucket sides and bottoms	Mixer blades
Tillage tools	Fan blades

Welding Parameters - DC Straight or Reverse Polarity

Diameter	.045" (1.2mm)	1/16" (1.6mm)	7/64" (2.8mm)
Current <i>amps</i>	140-200	170-300	250-450
Voltage (DCRP) <i>volts</i>	18-24	22-28	26-30
Stickout <i>inch (mm)</i>	3/4"-1" (18-25mm)	1"-1 1/2" (25-35mm)	1 1/2" (40mm)
Gas Flow <i>cfh (l/hr)</i>	NA	NA	NA

When welding out of position, use .045 with reverse polarity and the lower range of amperages and voltages.

Weld vertical down with 3/4" (18mm) wide weave beads. A gas cover will be helpful, especially when using a constant current power source and voltage sensing feeder.

Packaging

Diameter	.045" (1.2mm)	1/16" (1.6mm)	7/64" (2.8mm)
25 Lb. Spools	Standard	Standard	NA
55 Lb. Coils	NA	Available	Standard
110, 220 Lb. Drums	Available	Available	Standard