



TECHNIWEAR 60NC[®]

Data Sheet

Description

The UNIBRAZE Techniwear 60NC is a martensitic tool steel type alloy with numerous tightly packed carbides for excellent abrasion resistance under high impact. Deposits are smooth and free of any slag. One layer deposits exhibit wear characteristics that you would expect from chromium carbide hardfacing products. Techniwear 60NC is an excellent choice for applications requiring crack free deposits that will not chip or spall off with good wear characteristics.

Specifications

Product Type: Metal-cored, gas-shielded
Deposits are slag-free

Weld Deposit Properties

Average Hardness: 57-60 Rc
Maximum overlay: Unlimited with proper procedures
Non-Machinable: Must be ground

Welding Parameters

Current: Reverse (DCEP)

Diameter	Amps	Volts	CFH	Stick Out
1/16"(1.6mm)	160-300 (Typical 280A)	26-32 (Typical 30V)	30 - 35	3/4"-1-1/4" (19-32mm)

Gas is 98% Argon/2% Oxygen. Preheat temperature is 350/450°F (165/232°C) with maximum interpass temperature of 700 °F (370°C). Slow cool to room temperature.

Packaging Options

Diameter: Special Packaging Available
1/16"(1.6mm) 25 lb spool or 50 lb spool

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.