



TECHNIWEAR 61-O®

Data Sheet Rev17-11

Description:

A premium gasless (open-arc) chromium carbide alloy that has a high volume fraction of carbides dispersed in a hard iron 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
Deposits are slag-free

Weld Deposit Properties:

Average Hardness: 58 - 62 Rc
Deposit Thickness: 1 to 2 layers
Deposits cannot be flame cut
Deposits will check-crack to relieve stresses

Applications

Scrapper blades	Auger flights	Grinding/pulverizing rolls
Road ripper teeth	Screw conveyors	Wear Plates
Bucket teeth bucket sides/bottoms	Mixer blades	Clad Pipe
Tillage tools	Fan blades	Hammers

Welding Parameters - DC Straight Polarity (Electrode Positive)

Diameter	.045" (1.2mm)	1/16" (1.6mm)	3/32" (2.4mm)
Current <i>amps</i>	140-200	190-280	230-370
Voltage (DCRP) <i>volts</i>	23-27	23-28	26-30
Stickout <i>inch (mm)</i>	1/2" -1" (18-25mm)	3/4"-1 1/4" (25-35mm)	3/4"-1 1/4" (25-35mm)
Gas Flow <i>cfh (l/hr)</i>	NA	NA	NA

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

Packaging

Diameter	.045" (1.2mm)	1/16" (1.6mm)	3/32" (2.4mm)
25 Lb. Spools	Standard	Standard	NA
55 Lb. Coils	NA	Available	Standard
110, 220 Lb. Drums	Available	Available	Standard

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.