



## Techniwear® Buildup-O

**Techniwear® Buildup-O** is an open arc, low alloy steel flux cored wire designed for buildup on carbon and low alloy steels without shielding gas. It provides a tough underlayment upon which subsequent hardfacing layers may be placed. It may also be used as the final hardfacing layer where metal to metal wear is non-severe. The deposit is machinable with excellent compressive strength and crack resistance. Buildup thickness is generally unlimited with proper welding procedures. Applications include steel mill rolls, shafts, steel hammers, gear teeth, shovel pads etc. However, it is not designed for joining applications.

### Deposit Properties:

Chemistry: Fe-Mn-Cr

Hardness (4 layers): Rc 25-35

### Recommended Welding Parameters:

Part Number	Diameter	Polarity	Amps	Volts	ESO
TECHBUO04525	.045" x 25# spool	DCRP	175-300	23-28	½" - 1"
TECHBUO11625	1/16" x 25# spool	DCRP	225-325	23-30	¾" - 1"

**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.