TECHNIWEAR 56®

Data Sheet

Description:

A general purpose self-hardening overlay with a good combination of resistance to abrasion and impact. TECHNIWEAR 56 is very tough with excellent resistance to chipping and spalling. Deposits will retain their hardness and maintain a good cutting edge up to 1100 F (595 C).

Specifications

Wire Type: Cored, gas-shielded

Alloy Content: Carbon, Chromium, Manganese, Silicon, Molybdenum

Weld Deposit Properties:

Average Hardness: 55 -59 Rc
Good Hot-hardness: up to 1100º F (595 C)
Maximum overlay: 2 - 3 layers
Non-Machinable: must be ground

Applications

Hot Shear Blades	Dozer Blades
Shearing and piercing dies	Bucket Teeth
Farm Implements	Augers

Welding Parameters – Use DC Reverse Polarity (DCEP)

SHORT-ARC **SPRAY-ARC** **PULSED SPRAY ARC WELDING**

Use Ar/Ox (98/2) gas with 120 pps

	.035	.045	1/16	.035	.045	1/16
Amps	80-140	90-200	150-220	120-160	250-325	300-375
Volts	15-21	15-22	18-23	24-26	27-30	27-30
Gas	Ar/CO2	ArCO2	ArCO2	ArCO2	ArCO2	ArCO2
CFH	25-30	25-30	25-30	40-45	40-45	40-45
Stick-out	1/2“	1/2“	3/4”	1/2“	5/8”	3/4”

	.045	1/16
Current	200 220 250	250 275 300
Peak Amps	350 375 425	350 375 400
Volts	24 25 26	24 25 26
CFH	40-45	40-45
Stick-out	5/8”	3/4”

When welding out-of-position, use the lower ranges of voltages and amperages.
Use Ar/CO2 (75/25) or Ar/Ox (98/2) gas.

Packaging

Diameter	**.045” (1.2mm)**	**1/16” (1.6mm)**
25 Lb. Spools	Standard	Standard

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