



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 1100° 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	.045			1/16			
Amps	80-140	90-200	150-220	120-160	250-325	300-375	Current	200	220	250	250	275	300
Volts	15-21	15-22	18-23	24-26	27-30	27-30	Peak Amps	350	375	425	350	375	400
Gas	Ar/CO2	ArCO2	ArCO2	ArCO2	ArCO2	ArCO2	Volts	24	25	26	24	25	26
CFH	25-30	25-30	25-30	40-45	40-45	40-45	CFH	40-45			40-45		
Stick-out	1/2"	1/2"	3/4"	1/2"	5/8"	3/4"	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

Notice: The results reported are based upon testing of the product under controlled laboratory conditions. 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 product.