



Techniwear 21E

Flux-Coated Hardfacing Electrode

Features

- Flux-coated electrode
- Deposits are dense, crack-free, and porosity-free
- Deposits are extremely tough and have a high resistance to impact and deformation and are not subject to spalling or roll-over

Applications

- Rebuilding badly worn machine parts back to original dimensions
- Roll ends
- Shafts
- Buildup of parts prior to overlaying with a more wear resistant overlay
- Brake drums
- Wheels
- Tractor rolls
- Rails
- Idlers
- Gear teeth
- Wobblers
- Sprockets
- Dredge pump casing
- Trunnions

Diameters & Packages

Diameter	10 lb
0.125" (1/8")	✓
0.156" (5/32")	✓
0.187" (3/16")	✓

Technical Specifications

- **Average Hardness:** Up to 31 HRC
- **Deposit Thickness:** As required
- **Impact Resistance:** Excellent
- **Compressive Strength:** High
- **Abrasion Resistance:** Fair
- Can be flame-cut
- **Wire Equivalent:** Techniwear 41-O (Open Arc) and Techniwear 40-G (Gas-Shielded)

Recommended Weld Parameters:

Diameter	Amps
0.125" (1/8")	90-120
0.156" (5/32")	120-150
0.187" (3/16")	160-180

- **Welding Procedure:** Clean weld area. Preheat heavy sections to about 250°F. Use stringer or weaving technique holding a short to medium arc. Long deposits may be made without danger of cracking. Do not allow excessive heat buildup. Chip slag between passes. Allow part to cool slowly.