



Techniwear 31

Flux Coated Hardfacing Electrode

Features

- Flux-Coated Electrode
- For high abrasion and mild impact applications.
- Deposits take on a high polish, producing excellent frictional and sliding abrasion resistance.
- For use on carbon and alloy steels, stainless steels, and cast iron.
- Easy slag removal and excellent welder appeal.
- Machinability – best by grinding.
- Deposits are slightly magnetic on carbon and low alloy steels, but not on manganese steels, and will develop cross checks.

Applications

- Farm implements
- Crushing and pulverizing tools
- Road ripper teeth
- Grader blades
- Conveyor & feed screws
- Dredge pump impellers

Diameters & Packages

Diameter	10 lb
0.093"	✓
0.125"	✓
0.156"	✓
0.187"	✓

Technical Specifications

- **Average Hardness:** 56 to 60 HRC
- **Deposit Thickness:** 2-3 Passes
- **Current:** AC or DC Reverse or Straight
- Relief checks readily to prevent stress build-up
- Cannot be flame-cut
- Wire Equivalent: Techniwear 61

Recommended Weld Parameters:

Diameter	Amps
3/32"	70-110
1/8"	90-130
5/32"	100-150
3/16"	140-190

- **Welding Procedure:** Due to lower dilution, DC straight polarity will produce a higher first pass hardness and is also ideal for thin sections. Remove all damaged or fatigued metal. Preheating is generally not required. However, for high carbon or alloy steels and cast iron, a preheat of approximately 400°F is recommended. Maintain a short to medium arc using a weave technique. Remove slag.