



Techniwear 40-G

**Metal-Cored, Gas Shielded
Hardfacing Filler Metal**

Features

- Metal-cored, gas shielded wire
- Medium hardness build-up welding wire with excellent compressive strength.
- Deposits are slag free
- For use on carbon and low alloy steels.
- A strong, tough, low alloy build-up metal-cored gas shielded hardfacing wire.

Applications

- Machine components
- Gear teeth
- Steel mill parts
- Under carriage idlers and rollers
- Carbon steel railroad track components
- Keyways

Diameters & Packages

Diameter	25 lb
0.045"	✓
0.062" (1/16")	✓

Technical Specifications

- **Average Hardness:** 30-35 HRC
- **Maximum Deposit Thickness:** Unlimited with proper preheat
- Deposits can be flame-cut
- Machinable with carbide tools
- Good resistance to compression and plastic deformation.
- Electrode Equivalent: Techniwear 21E

Recommended Weld Parameters:

Diameter	Volts	Amps	Stick Out
0.045"	15-21	90-200	3/4"
0.062" (1/16")	18*21	150-220	3/4"-1"
0.045"	27-30	250-325	3/4"
0.062" (1/16")	27-30	300-375	3/4"-1"