



Techniwear 52

**Flux-Cored, Open-Arc
Hardfacing Filler Metal**

Features

- Flux-cored, open arc wire
- Deposits have very good frictional wear properties and are ideal for railroad applications requiring metal-to-metal wear resistance.
- Weld deposits have an excellent combination of weld metal strength, ductility and hardness.
- Open-arc hardfacing wire that deposits fully austenitic chromium-manganese weld metal.
- It can be used equally well for joining and build-up/surfacing of carbon, low alloy and manganese steels.
- Weld deposits have an excellent combination of weld metal strength, ductility and hardness.
- Work-hardens rapidly under repeated impact.
- Ideal as a cushioning or buffer layer on manganese steel parts.
- May be used on a variety of steels including austenitic manganese steels.

Applications

- Pulverizing hammers
- Gyrotory crusher mantles
- Dragline and power shovel bucket lips and teeth
- Crusher rolls and jaws
- Sizing screens
- Cone and roll shells
- Grizzly bars
- Hammer mill hammers

Diameters & Packages

Diameter	25 lb	55 lb
0.045"	✓	
0.062" (1/16")	✓	
0.109" (7/64")		✓

Technical Specifications

- **Tensile Strength:** 122,000 psi
- **Yield Strength:** 80,000 psi
- **Elongation:** 40%
- **Hardness as Deposited:** 20 HRC
- **Work Hardened:** 45-55 HRC
- **Machinability:** Poor
- **Current:** DC Electrode Positive and Glovular Metal Transfer
- Deposits cannot be flame-cut
- Cannot be flame-cut

Recommended Weld Parameters:

Diameter	Volts	Amps	Stick Out
0.045"	24-28	100-175	¾"-1"
0.062" (1/16")	26-29	150-250	1"-1 ¼"
0.109" (7/64")	24-28	300-450	1 ¼"-1 ½"