



Techniwear 55

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

Features

- Flux-cored, open arc wire.
- Deposits are very tough, and work-harden rapidly in service as plastic deformation occurs during impact.
- Designed for buildup, hardfacing and fabricating of manganese steel.
- Open-Arc wire for convenience and use in the field or shop

Applications

- Crusher jaws
- Hammer mill hammers
- Cones and roll shells
- Impact breaker bars
- Gyratory crusher mantels
- Joining of manganese steel components

Diameters & Packages

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

Technical Specifications

- **Tensile Strength:** 120,000 psi
- **Yield Strength:** 75,000 psi
- **Elongation:** 45%
- **Hardness as Deposited:** 16-20 HRC
- **Work Hardened:** 50+ HRC
- **Number of Layers:** Unlimited
- **Current:** DC Electrode Positive and Globular Metal Transfer
- Can be flame-cut
- **Electrode Equivalent:** Techniwear 55-E

Recommended Weld Parameters:

Diameter	Volts	Amps	Stick Out
0.045"	19-27	100-200	¾"-1"
0.062" (1/16")	23-28	150-300	1"-1 ¼"
0.109" (7/64")	23-30	240-400	1 ½"

- **Welding Procedure:** When welding out of position it is best to use a shielding gas of 100% CO₂ at 40-45 cfh and DC Straight Polarity. Welding should proceed vertical-down with 1" wide weave beads.