Techniwear 56-E

Flux-Coated Hardfacing Electrode

Features

- Flux-Coated Electrode
- General purpose self-hardening overlay with a good combination of resistance to abrasion
- Good resistance to spalling and chipping while the special low hydrogen coating minimizes dilution and helps to eliminate under-bead cracking.
- For use on carbon and low alloy steels
- Forgeable deposit can be heat treated

Applications

- Excavator Parts
- Bucket Teeth
- Tamping Tools
- Screw Conveyors
- Elevator Bucket Lips
- Dozer and graber blades
- Post hole augers
- Wear areas on clam shell buckets
- Mining drag line and shovel buckets
- Earth moving and construction equipment
- Muller tires
- Grader end bits

Diameters & Packages

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

Technical Specifications

- **Average Hardness:** 56-60 HRC
- **Deposit Thickness:** Unlimited with proper procedures
- **Current:** AC or DC Reverse or Straight
- **Wire Equivalent:** Techniwear 57-O (Open Arc) and Techniwear 56-G (Gas-Shielded)
- **Machinable:** Best by Grinding

Recommended Weld Parameters:

Diameter	Amps
0.125” (1/8”)	90-135
0.156” (5/32”)	130-160
0.187” (3/16”)	150-225

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.

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