



Techniwear 56-G

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

Features

- Metal-cored, gas shielded wire
- Deposits are slag free
- Gases: Ar/CO, Ar/Ox.
- Excellent resistance to chipping and spalling.
- General purpose self-hardening overlay with a good combination of resistance to abrasion and impact.
- Forgeable deposit can be heat treated
- Use on carbon and low alloy steels
- Superior wire feeding characteristics and low contact tip wear
- May be used on a variety of steels including austenitic manganese steels

Applications

- Hot Shear Blades
- Dozer Blades
- Shearing and Piercing Dies
- Tamper Feet
- Bucket Teeth
- Farm Implements Augers

Diameters & Packages

Diameter	10 lb	25 lb
0.035"	✓	✓
0.045"	✓	✓
0.062" (1/16")		✓

Technical Specifications

- **Average Hardness:** 55-59 HRC
- **Good Hot-Hardness:** Up to 1100°F
- **Maximum Overlay:** Unlimited layers with proper procedures, including preheat and interpass temperature
- **Non-Machinable:** Must be ground
- **Current:** DC Reverse Polarity
- **Electrode Equivalent:** Techniwear 56E

Recommended Weld Parameters:

Diameter	Volts	Amps	Stick Out
0.045"	18-24	140-200	¾"-1"
0.062" (1/16")	22-28	170-300	1"-1 ¼"