



Techniwear 57-0

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

Features

- Flux-Cored, Open-Arc wire
- General purpose, hardfacing wire designed to resist wear in applications involving a combination of abrasion, impact, and pressure.
- Forgeable deposit can be heat treated
- Use on carbon and low alloy steels
- For use in metal-to-metal-to-earth wear applications.
- Multiple layers can be applied with proper preheat and interpass temperature.

Applications

- Tillage tools
- Bulldozer blades and end bits
- Conveyor screws
- Dragline scrapers
- Backhoe buckets
- Dragline chain idlers
- Clamshell buckets
- Agitator bearings and shafts
- Shovel and dragline bucket lips and teeth
- Sprockets
- Tractor grousers
- Gudgeon hangers and pins

Diameters & Packages

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

Technical Specifications

- **Hardness:** 55-59 HRC
- **Maximum Overlay:** Unlimited layers with proper procedures, including preheat and interpass temperature
- **Non-Machinable:** Must be ground
- Non-cracking with proper preheat and postheat temperatures
- **Machinability:** Best by grinding or machining with special tooling
- Use DC Reverse Polarity and Globular Metal Transfer
- 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"