



# Techniwear 59 Tic-O

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

## Features

- Flux-cored, open arc wire
- Contains a fine dispersion of ultra-hard titanium carbides in a tough, martensitic matrix, providing excellent resistance to combined wear by abrasion, impact and/or pressure.
- Use on carbon and low alloy steels
- Produces full slag coverage that does not require removal between passes. Slag is easily removed with a chipping hammer
- Multiple layers maintain their hardness and abrasion resistance.
- Excellent welding characteristics.

## Applications

- Cement rolls
- Hardbanding drill pipes
- Hammers
- Bucket pins
- Shredder & Fibrizier hammers
- Bucket teeth and lips
- Tillage implements
- Augers
- Asphalt mixer paddles

## Diameters & Packages

Diameter	25 lb	55 lb
0.062" (1/16")	✓	
0.093" (3/32")		✓
0.109" (7/64")		✓

## Technical Specifications

- **Average Hardness:** 57-60 HRC
- **Good Hot-Hardness:** Up to 1100°F
- **Maximum Overlay:** Unlimited layers with proper procedures, including preheat and interpass temperatures
- **Non-Machinable:** Must be ground
- Cannot be flame-cut
- Use DC Electrode Positive

### Recommended Weld Parameters:

Diameter	Volts	Amps	Stick Out
0.062" (1/16")	26-29	210-250	1"-1 ¼"
0.093" (3/32")	26-30	280-340	1"-1 ½"
0.109" (7/64")	26-30	325-500	1"-1 ½"

- **Welding Procedure:** Out of position welding is limited to horizontal stringers. Preheats and interpass temperatures should be based on base metal chemistry.