TECHNIWELDUSA

Techniwear 60

Metal-Cored, Open-Arc, or Gas Shielded Hardfacing Filler Metal

Features

- Metal-cored, open arc, or gas shielded wire
- Deposits are slag free
- For use in applications involving high abrasion and moderate impact.
- May be used on a variety of steels including austenitic manganese steels
- Open-Arc wire for convenience and use in the field or shop
- For use on low carbon, mild steel, manganese, stainless, and low alloy steels

Applications

- Tampers
- Dredge bucket lips
- Dredge pump side plates
- Coal pulverizing hammers
- Grizzley bars
- Dredge cutter heat & teeth
- Bulldozer blades
- Crusher rolls
- Shredder & Fibrizer Hammers
- Clamshell bucket lips
- Dragline buckets
- Crusher jaws and cones
- Power shovel buckets and teeth
- Gyrator crusher mantles
- Road rippers and scraper blades
- Muller tires
- Augers
- Sugar mill roll teeth

Diameters & Packages

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

Technical Specifications

- **Average Hardness:** 54-60 HRC
- **Deposit Thickness:** 1-3 layers
- Deposits cannot be flame-cut
- Deposits will check-crack to relieve stresses
- Use DC Electrode Negative
- Heat resistant to 1000°F
- Good out of position capabilities
- Fast freezing weld deposit
- Very good weld bead tie-in
- Ideal for dirty surfaces
- Works well for sugar mill roll teeth
- Cannot be flame-cut
- Electrode Equivalent: Techniwear 31

Recommended Weld Parameters:

Diameter	Volts	Amps	Stick Out
0.045”	21-27	120-140	¾”-1”
0.062” (1/16”)	22-28	170-300	1”-1 ¼”

- **Welding Procedure:** Out of Position:

Diameter: 0.045”, **Amps:** 80-130, **Volts:** 16-19, **Stick-Out:** 3/8” – 5/8”

Diameter: 0.062” (1/16”), **Amps:** 100-140, **Volts:** 16-20, **Stick-Out:** 3/8” – 5/8”

When welding out of position, lower wire feed speed.

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