



Techniwear 64-G

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

Features

- Metal-cored, gas shielded wire
- This is a metal cored wire that was developed to produce multi-pass crack-free hardfacing layers for parts that are exposed to wear when they come into contact with abrasion and high pressure.
- Deposits are slag free
- For use in applications involving high abrasion and mild or moderate impact.

Applications

- Scraper blades
- Road ripper teeth
- Bucket teeth
- Tillage tools
- Auger flights
- Mixer blades
- Fan blades
- Shredder & Fibrizier Hammers

Diameters & Packages

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

Technical Specifications

- **Average Hardness:** 57-61 HRC
- **Maximum Overlay:** Unlimited layers with proper procedures, including preheat and interpass temperatures
- **Non-Machinable:** Must be ground
- **Shielding Gas:** 98% Argon/2% Oxygen or high Argon content
- **Current:** DC Electrode Positive
- Use on carbon and low alloy steels
- Deposits cannot be flame-cut

Recommended Weld Parameters:

Diameter	Volts	Amps	Stick Out
0.045"	24-28	125-170	¾"-1"
0.062" (1/16")	26-32	160-300	¾"-1 ¼"

Welding Procedure: To avoid cracks preheat according to base metal chemistry carbon content. A minimum preheat temperature of 350-450°F with maximum interpass temperature of 700°F. Slow cool to room temperature. DCEN can be used for some applications to reduce dilution. DCEN will produce more spatter. With DCEN, 95/5 Argon/CO2 is recommended.