



Techniwear 65

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

Features

- Metal-cored, open arc wire
- Techniwear 65 offers superior resistance to grinding and gouging abrasion combined with pressure and moderate to medium impact at elevated temperatures
- Open-Arc wire for convenience and use in the field or shop
- Consistent crack pattern makes it an excellent choice for multi-layer hardface applications. This helps reduce the probability of spalling and chipping.
- The weld deposit will withstand hot wear applications up to 1000°F
- Can be applied to carbon steels, manganese steels and cast iron rolls

Applications

- Sugar Mill Rolls
- Wear Plates
- Gyratory Mantles
- Pulverizer Rolls
- Grinding Rings

Diameters & Packages

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

Technical Specifications

- **Average Hardness:** 60-66 HRC
- **Impact Resistance:** Moderate
- **Current:** DC Electrode Positive
- Non-machinable
- Will stress relieve, consistent check crack pattern
- May be used on a variety of steels including austenitic manganese steels

Recommended Weld Parameters:

Diameter	Volts	Amps	Stick Out
0.045"	20-26	100-225	¾"-1"
0.062" (1/16")	24-28	200-250	1"-1 ¼"