



Techniwear 67-G

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

Features

- Metal-cored, gas shielded wire
- Non-cracking abrasion resistant, gas-shielded, modified high speed tool steel welding wire designed for applications where edge retention is a primary concern.
- For use on carbon and low alloy steels.

Applications

- Hot or cold trim dies
- Shear blades
- Blanking dies
- Cutting tools
- Shearing and piercing dies
- Tire recycling knives

Diameters & Packages

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

Technical Specifications

- **Average Hardness:** 60-65 HRC
- **Good Hot-Hardness:** Up to 1150°F
- **Maximum Overlay:** 2-3 Layers
- **Non-Machinable:** Must be ground
- **Current:** DC Electrode Positive
- Deposits are slag-free

Spray Arc:

Diameter	Volts	Amps	Stick Out
0.045"	28-30	250-390	3/4"
0.062" (1/16")	28-30	250-390	3/4"-1"

Pulsed Spray Arc:

Diameter	Current	Peak Amps	Stick Out
0.045"	180-300	350-450	3/4"
0.062" (1/16")	180-300	350-450	3/4"-1"