



Techniwear VC-O

Tubular Metal-Cored Hardfacing Filler Metal

Features

- Metal-cored, open arc wire
- Ideally balanced to provide a uniform distribution of vanadium – tungsten carbides throughout a tough steel matrix that takes more impact than both chromium and tungsten carbides
- For use on carbon and low alloy steels

Applications

- Ammonia injector knives
- Conveyor screws
- Ditch and trenching teeth
- Debarking hammers
- Augers
- Shredder and Fibrizer hammers
- Drill collars
- Dozer end bits
- Grinding equipment
- Recycling wear parts
- Stabilizers
- Shovel bucket sides, lips, teeth, and adapters
- Rippers
- Shredder hammers
- Sub-soilers
- Sugar cane cutting knives
- Sugar cane hammers
- Fibrizer cane hammers

Diameters & Packages

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

Technical Specifications

- **Average Hardness:** 59-61 HRC
- **Deposit Thickness:** 1-2 Layers
- **Service Temperature:** Up to 1000°F
- **Deposit Layers:** Multiple
- **Non-Machinable:** Must be ground
- Does not check-crack with proper welding procedures
- Cannot be flame cut
- Deposits are slag-free

Recommended Weld Parameters:

Diameter	Volts	Amps	Stick Out
0.062" (1/16")	22-26	170-300	3/4"-1"
0.093" (3/32")	25-27	240-400	1"-1 1/4"