



Techniwear 61

Premium Chromium Carbide Hardfacing Alloy

Features

- Metal-cored, open arc, or gas shielded wire
- Deposits are slag free
- For use in applications involving high abrasion and mild or 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 carbon, low alloy steel, and manganese steel

Applications

- Scraper blades
- Auger flights
- Road ripper teeth
- Screw conveyors
- Fan blades
- Tillage tools
- Mixer blades
- Bucket sides and bottoms
- Bucket teeth
- Shredder and Fibrizer Hammers

Diameters & Packages

Diameter	10 lb	25 lb	55 lb
0.045"	✓	✓	
0.062" (1/16")		✓	
0.093" (3/32")			✓
0.109" (7/64")			✓

Technical Specifications

- **Average Hardness:** 58-62 HRC
- **Deposit Thickness:** 1-3 layers
- Deposits cannot be flame-cut
- Deposits will check-crack to relieve stresses
- Use DC Electrode Positive
- Heat resistant to 1000°F
- Cannot be flame-cut
- Electrode Equivalent: Techniwear 31

Recommended Weld Parameters:

Diameter	Volts	Amps	Stick Out
0.045"	18-24	140-200	3/4"-1"
0.062" (1/16")	22-28	170-300	1"-1 1/4"
0.093" (3/32")	25-29	240-400	1"-1 1/2"
0.109" (7/64")	26-32	250-450	1"-1 1/2"

- **Welding Procedure:** When welding out of position, use 0.045 with reverse polarity and the lower range of amperages and voltages. Weld vertical down with 3/4" wide weave beads. A gas cover will be helpful, especially when using a constant current power source and voltage sensing feeder.