



## TECHNIWEAR 56

Data Sheet

### Description:

A general purpose self-hardening overlay with a good combination of resistance to abrasion and impact. Techniwear 56 is a very tough with excellent resistance to chipping and spalling. Deposits will retain their hardness and maintain a good cutting edge up to 1100° F (565° C).

### Specifications

Wire Type: Metal-cored, gas-shielded  
Deposits are slag-free

Alloy Content: Carbon, Chromium, manganese, Silicon, Molybdenum

### Weld Deposit Properties:

Average Hardness: 55- 59 Rc  
Good Hot-hardness: up to 1100° F (595° C)  
Maximum overlay: 2 – 3 layers  
Non-mechinable: must be ground

### Applications

Hot Shear Blades                      Dozer Blades  
Shearing and piercing dies        Bucket Teeth  
Farm Implements                      Augers

Welding Parameters – Use DC Reverse Polarity (DCEP)

	SHORT-ARC		SPRAY-ARC		PULSED SPRAY ARC WELDING						
					Use 98/2 Argon/Oxygen with 120 pps						
	<b>.045</b>	<b>1/16</b>	<b>.045</b>	<b>1/16</b>	<b>.045</b>	<b>1/16</b>					
Amps	90-200	150-220	250-325	300-375	Current	200	220	250	250	275	300
Volts	15-21	18-21	27-30	27-30	Peak Amps	350	375	425	350	375	400
Gas	Ar/CO <sub>2</sub>	Ar/CO <sub>2</sub>	Ar/Ox	Ar/Ox	Volts	24	25	26	24	25	26
CFH	25-30	25-30	40-45	40-45	CFH	40-45			40-45		
Stick-out	½" (12mm) ¾" (18mm)		5/8" (15mm) ¾" (18mm)		Stick-out 5/8" (15mm) 3/4" (18mm)						

When welding out-of-position, use the lower ranges of voltages and amperages: 16-19 volts and 100-150 amps.

### Packaging

Diameter                      .045" (1.2mm)                      1/16" (1.6mm)  
25 lb. Spools                      Standard                      Standard