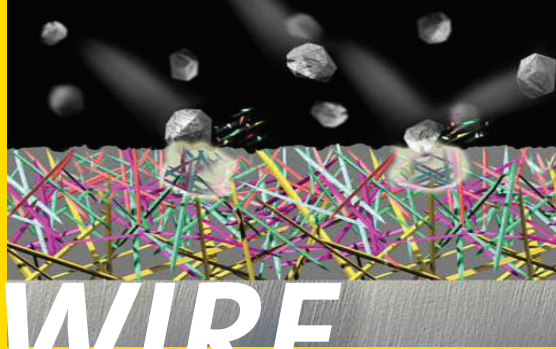


Premium Open Arc, Wearfacing Wire for Combating Abrasion with Impact

# 5716 FW - Chrome Iron



## WIRE

- Economical, welder friendly wear-facing wire
- Resistant to sliding abrasion with some impact
- Excellent for crushing and grinding operations



## DESCRIPTION:

5716 FW is a small-diameter, open-arc wire for applications requiring precise, low-heat deposits. Hexagonal carbides in a Chromium reinforced matrix make 5716 excellent for resistance to grinding, fine particle and 3-body abrasion with low to moderate impact, especially for lower power rated machines and applications that cannot easily be dismantled and moved for hardfacing.

## TECHNICAL DATA:

Hardness as-deposited (3-passes max.): 55-58 HRC  
Wear Data (ASTM G65 Test): 35 mm<sup>3</sup>  
Power Source Type: Constant voltage and Integrated Wire Drive  
Current & Polarity: DC (+) electrode positive

## APPLICATIONS:

### APPLICATIONS

- Cement Grinder Rings
- Ash plows
- Bucket Lips
- Pug Mill Blades
- Refuse crusher Rolls
- Bucket Teeth

### INDUSTRY

Cement  
Public Services, Power Gen.  
Mining, Quarrying  
Cement, Materials  
Scrap Processing,  
Mining, Quarrying

## OPEN ARC PARAMETERS

DIAMETER	VOLTAGE	AMPERAGE	STICK-OUT
0.045"	24-28	190-210	5/8 ± 1/8"
1/16" (1.6mm)	25-28	190-250	3/4" - 1/16" (Short nozzle)

## PROCEDURE FOR USE:

**Caution:** Although a 2-roll wire drive assembly will work the optimum for maintaining arc voltage stability and consistent and smooth wire feeding is a serrated 4-roll drive assembly. Smooth drive rolls are not recommended!

Step 1: Remove all "old" cracked or spalled weld metal down to a sound base.

Step 2: 5716 has a maximum of 3 layers. Depending on the amount of build-up or repair required, the use of a bond or cushion may be necessary. If unsure, consult a professional.

Step 3: Preheat the part to be hardfaced depending on its air hardenability and/or carbon level.

**Note:** 5716 is an open-arc wire, however CO<sub>2</sub> with a 35-45 scfh can be used if desired to cool the gun and reduce fuming.

Step 4: After testing welding conditions on a piece of scrap metal, position the gun head at 70-80° from the vertical in the direction of travel. Continue with a downhand 'pull' technique to apply stringer or a slight weaving bead. Avoid excess weaving as it may result in porosity, insufficient penetration, overheating and/or reduced deposit properties.

**Note:** If welding is interrupted and the part being welded cools to room temperature, make sure to reheat to the original preheat temperature.

Step 5: For hardenable steels slow cooling is advised using blankets, vermiculite, or other environmentally suitable heat-retardant material.

## YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



EUTECTIC CORPORATION  
N94 W14355 Garwin Mace Drive  
Menomonee Falls, WI 53051 USA  
Tel.: +1 (800) 558-8524  
eutectic.com

EUTECTIC CANADA  
428, rue Aimé-Vincent  
Vaudreuil-Dorion, Québec  
J7V 5V5 Canada  
Tel.: +1 (800) 361-9439  
eutectic.ca

