



## SelectWear 52W

### Alloy Group

Martensitic Tool Steel

### Description:

**SelectWear 52W** deposits a martensitic alloy similar in composition to an H-12 tool steel. It may be used for hot wear applications up to 1100F. Abrasion resistance and hardness are high without stress relief check cracking. Multiple layers are possible when proper welding procedures are followed. It can be machined, but not easily.

### Applications:

Designed for metal-to-metal wear resistance: Steel mill edger rolls, work rolls, leveler rolls, blast furnace bell seat areas, forging dies

### Deposit Properties

Chemistry: Fe-Cr-W-Mo-C  
Hardness (2 layer): Rc50-55  
Machinable with carbide tools  
Will not cross crack

### Weld Parameters

#### 52W-FCO - Open arc, flux cored wire

.045"	DCRP	150-200	24-29½-1"
1/16"	DCRP	200-250	26-30¾-1¼"
7/64"	DCRP	350-500	26-31 1¼-1¾"
1/8"	DCRP	400-550	27-32 1¼-1¾"

#### 52W-MCG - Gas shielded metal cored wire (Ar-2% O<sub>2</sub>)

.035"	DCRP	130-220	23-28½-¾"
.045"	DCRP	160-250	25-30½-1"
1/16"	DCRP	200-350	24-32¾-1¼"

#### 52W-S - Sub-arc wire (In Lincoln 802 flux)

1/8"	DCRP	350-600	27-30 - 1¼-1¾"
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Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. Select-Arc disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.