

SelectWear 42

Description

SelectWear 42 is a low alloy, martensitic electrode that produces a deposit of medium hardness (R_C40-44). It has good metal to metal wear resistance. With proper welding procedures multiple layers may be welded without cracking.

Alloy Group

Medium Alloy Martensitic Steel

Applications

Designed for metal-to-metal wear resistance: Earthmoving idlers and rollers, mine car and crane wheels. It is also used to overlay welds that have joined abrasion resistant plates, such as AR400, The deposit has earth-to-metal wear resistance similar to the abrasion resistant plate.

Deposit Properties

- Chemistry: Fe-Cr-Mn
- Hardness (3 layers): R_C40-45
- Machinable with carbide tools
- Will not cross crack

Weld Parameters

42-FCG - Gas shielded flux cored wire (CO₂ or Ar-25% CO₂)

Diameter	Polarity	Current (amps)	Voltage ESO		
.045"		DCRP	200-300	25-29	½"-1"
1/16"		DCRP	225-325	26-30	¾"-1¼"

Note: Listed parameters are for CO₂ shielding. Lower by one volt for Ar-25% CO₂.

42GV-FCG Out-of-position flux cored wire (CO₂ or Ar-25% CO₂)

Diameter	Position	Optimum			Range	
		Amperage	WFS	Voltage	Amperage	Voltage
.045"	Flat	250	450	29	100-350	21-32
	Overhead	220	330	26	150-280	21-29
	Vertical up	220	330	25	100-230	21-28
1/16"	Flat	300	330	29	150-400	22-32
	Overhead	210	175	26	150-310	22-28
	Vertical up	210	175	25	150-280	22-27

* With CO₂ shielding gas. For 75Ar/25CO₂ decrease voltage by 1 to 1.5 volts.

42-FCO - Open arc, flux cored wire

.045"	DCRP	150-200	24-29	½"-1"
1/16"	DCRP	200-250	26-30	¾"-1¼"
7/64"	DCRP	350-500	26-31	1¼"-1¾"
1/8"	DCRP	400-550	27-32	1¼"-1¾"

42-MCG - Gas shielded metal cored wire (Ar-2% O₂ or Ar-CO₂ mixtures)

.035"	DCRP	150-240	25-33	½"-¾"
.045"	DCRP	180-300	27-33	½"-1"
1/16"	DCRP	240-450	26-35	¾"-1¼"

Note: Listed parameters are for Ar-25% CO₂ shielding. Lower voltage for higher argon levels.

42-S - For submerged arc welding is also available in various diameters



**SelectWear
42GV-FCG
Overlay on
Select 707**

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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.