

SelectWear 420

Description

SelectWear 420 is a composite metal cored electrode for use with external shielding gas. It yields a martensitic deposit that has high hardness with good scaling and corrosion resistance. This electrode is designed for the surfacing of carbon, low alloy and martensitic steel. The preferred shielding gas is argon with 2% oxygen.

Alloy Group

Martensitic stainless steel

Applications

Steel mill caster rolls, idler rolls

Deposit Chemistry (98% Ar-2%O₂)

<u>C</u>	<u>Mn</u>	<u>Si</u>	<u>Cr</u>	<u>Fe</u>
0.30	1.10	0.60	12.50	Balance

Deposit Hardness (98% Ar-2%O₂)

50 Rc

SW 420-MCG Recommended Welding Parameters (98% Ar-2%O₂)

<u>Diameter</u>	<u>Operating Range</u>			<u>Optimum</u>		
	<u>Amps</u>	<u>WFS</u>	<u>Voltage</u>	<u>Amps</u>	<u>WFS</u>	<u>Voltage</u>
.045"	180-330	240-600	22-28	255	410	25-26
1/16"	230-520	160-500	22-31	350	300	26

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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.