

SelectWear 50

Alloy Group

Medium Chromium Carbide

Description

SelectWear 50 produces a medium chromium carbide alloy deposit. It exhibits resistance to both moderate wear and impact. The weld deposit (Rc50-53) will normally cross check and is not machinable. Deposits should be limited to two layers. There are both open arc and gas shielded types available.

Applications

Designed for metal-to-earth wear resistance: Rock Crushing hammers and rolls, impactor bars, gyratory mantles, dredge components, augers and pug mill paddles

Deposit Properties

- Chemistry: Fe-Cr-C
- Hardness (2 layers): Rc50-54
- Non-machinable
- Deposits will cross crack

Recommended Welding Parameters

50-MCO - Open arc, metal cored wire

<u>Diameter</u>	<u>Polarity</u>	<u>Current (amps)</u>	<u>Voltage</u>	<u>ESO</u>
.045"	DCRP	150-200	24-29	½"-1"
1/16"	DCRP	200-250	26-30	¾"-1¼"
5/64"	DCRP	250-350	27-31	¾"-1¼"
7/64"	DCRP	300-400	26-31	1¼"-1¾"
1/8"	DCRP	350-450	27-32	1¼"-1¾"

50-MCG - Gas shielded, metal cored wire (Ar-2% O₂ or Ar-CO₂ mixtures can be used)

.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"
7/64"	DCRP	350-500	27-35	1¼"-1¾"
1/8"	DCRP	400-650	29-36	1¼"-1¾"

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

Rev 0 (03/17/2014)

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.