



**The Standard of Excellence  
in Tubular Welding Electrodes**

## SelectWear 60HB-MCO

### Description

SelectWear 60HB deposits an alloy with high hardness and high wear resistance. It does not rely on chromium content for its properties. It does not need shielding gas.

### Alloy Group

High hardness non-chromium containing hard surfacing alloy

### Applications

Designed for general hard surfacing application where high hardness, good metal-to-earth wear resistance and good impact resistance are required. It has very good resistance to metal-to-metal wear.

### Deposit Properties

- Chemistry: Fe-B-C
- Hardness (2 layers): Rc 62-66
- Not machinable
- Deposits do not cross check

### Recommended Welding Parameters

<u>Diameter</u>	<u>Polarity</u>	<u>Current (amps)</u>	<u>Voltage</u>	<u>ESO</u>
.045"	DCEP	150-200	23-27	½" - 1"
1/16"	DCEP	200-270	24-28	¾" - 1¼"
7/64"	DCEP	300-600	27-31	1" - 1¼"

**Rev 0 (03/05/2014)**

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.