



SelectWear 63

Description

SelectWear 63 deposits primary chromium carbides and secondary columbium carbides in a martensitic matrix. It has high abrasion resistance and moderate resistance to impact. Typical wear life is increased by 33% over standard chromium carbide alloys. **SelectWear 63** is designed for one or two layer deposits and will retain hardness and wear resistance into the 1200-1400°F range. The deposit will stress relief cross crack and it is not machinable.

Alloy Group

Complex Carbide

Applications

Designed for metal-to-earth wear resistance: Grinding/pulverizing rolls and table segments, wear plates, clad pipe, fan and mixer blades

Deposit Properties

- Hardness (2 layers): Rc61-65
- Non-machinable
- Deposits will cross crack

Recommended Welding Parameters

63-MCO - Open arc, metal cored wire

<u>Diameter</u>	<u>Polarity</u>	<u>Current (amps)</u>	<u>Voltage</u>	<u>ESO</u>
.045"	DCEP	150-200	23-27	1/2"-1"
1/16"	DCEP	200-270	24-28	3/4"-1 1/4"
5/64"	DCEP	220-350	24-29	3/4"-1 1/4"
7/64"	DCEP	300-450	24-31	1 1/4"-1 3/4"
1/8"	DCEP	450-650	26-34	1 1/4"-1 3/4"

Rev 2 (09/22/2016)

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.