



## SelectWear GP

### Alloy Group

Austenitic Manganese Steel

### Description

**SelectWear GP** is a premium grade austenitic manganese steel wire with a high chromium level. It produces a tough, impact resistant deposit that work hardens in use (the as deposited hardness of Rc20 will increase to Rc45-52). **SelectWear GP** is primarily used for the buildup and repair of manganese steel components. Weld deposits exhibit very good impact resistance. It is sometimes used as a final layer of hardfacing in high impact applications with moderate wear. It may also be used for the joining of austenitic manganese steel to itself or to carbon steel. The deposit thickness is unlimited and it has excellent crack resistance. Deposits are machinable.

### Applications

Designed for joining, repair and buildup: Manganese steel rock crushing hammers, rolls, buckets and teeth, impactor bars, gyratory mantles and dredge components

### Deposit Properties

**Chemistry:** Fe-Cr-Mn-C

**Hardness:** As welded - Rc22, work hardens to Rc45-52

Machinable with carbide tools

Will not cross crack

### Recommended Welding parameters

GP-FCO - Open arc, flux 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"

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.