

SelectWear 19MN-FCO

Hardsurfacing / Gas Shielded / Flux Cored

PRODUCT DATA SHEET

FEATURES

- Deposits an austenitic manganese steel which is tough, impact resistant, and work hardens in service
- Designed for severe impact and moderate abrasion
- Primarily used for the buildup, repair, and joining of manganese steel components
- Deposits are austenitic on both manganese steel and carbon steel
- Unlimited layers can be deposited with proper welding procedure
- Interpass temperature to be kept below 500°F
- Applications include: Crusher rolls, crusher hammers, crusher jaws, bucket teeth, dredge components, shovel pads, railroad components

DIAMETERS (in [mm])

0.045 (1.2), 1/16 (1.6), 5/64 (2.0), 7/64 (2.8), 1/8 (3.2)

POSITIONS



SHIELDING GAS

N/A

POLARITY

Direct Current Electrode Positive (DCEP)

HARDNESS

As deposited: 15-20 HRC. Work hardened: 45-55 HRC HRC

RECOMMENDED WELDING PARAMETERS **

Diameter in (mm)	Shielding Gas	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
0.045 (1.2 mm)	None	Flat & Horizontal	350 (8.9)	250	26	1/2 - 1 (13 - 25)
1/16 (1.6 mm)	None	Flat & Horizontal	250 (6.4)	300	27	3/4 - 1 1/4 (19 - 32)
5/64 (2.0 mm)	None	Flat & Horizontal	225 (5.7)	325	27	1 - 1 1/2 (25 - 38)
7/64 (2.8 mm)	None	Flat & Horizontal	160 (4.1)	470	28	1 - 1 3/4 (25 - 44)
1/8 (3.2 mm)	None	Flat & Horizontal	120 (3.0)	500	29	1 1/4 - 1 3/4 (32 - 44)

* WFS = Wire Feed Speed, CTWD = Contact Tip To Work Distance

**The parameters listed are recommended starting points of operation and the ranges for amperage, wfs, and voltage could be extended based on fitness for application. For products with "all-position" capability, as determined and listed in classification, the position recommendation can be determined based on operator skill and material thickness and isn't limited to the listing.

PACKAGING (lbs [kgs])

33 (15) Spools, 60 (27.2) Coils, 500 (226.8) Round Drum, 800 (362.9) Hex Drum, 900 (408.2) Hex Drum

*Some packaging options may not be available depending on diameter and product. Special package options may be available upon request.



Notice: Be sure to follow all your employers safety practices, policies and procedures when using this product. Refer to CSA W117.2 and ANSI Z49.1 Safety in Welding, Cutting and Allied Processes for further information and the manufactures SDS sheet. 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. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.

STORAGE AND HANDLING

All products should be stored in original packaging, in dry conditions and handled with care. For more information refer to our website.



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