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 (), 1/16 (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*

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.*

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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