

# SelectWear 420-S

Hardsurfacing / Flux Shielded / Submerged Arc

PRODUCT DATA SHEET

## FEATURES

- Designed for surfacing with submerged arc process, the deposit has good resistance to hot wear, fire cracking and corrosion
- Application: Predominantly caster rolls

## DIAMETERS (in [mm])

3/32 (2.4), 7/64 (2.8), 1/8 (3.2)

## POSITIONS



## FLUX

ArcFlux BF-1, BF-3.5, BF-8.7

## POLARITY

Direct Current Electrode Positive (DCEP)

## HARDNESS

43-48 HRC as welded HRC

## TYPICAL WELD DEPOSIT CHEMISTRY (WT%)

| Flux           | C    | Cr    | Fe      | Mn   | Si   |
|----------------|------|-------|---------|------|------|
| ARCFLUX BF 8.7 | 0.17 | 12.11 | Balance | 0.86 | 1.22 |

## RECOMMENDED WELDING PARAMETERS \*\*

| Diameter in (mm) | Flux           | Position          | WFS* in/min (m/min) | Amps | Volts | CTWD* in (mm)       |
|------------------|----------------|-------------------|---------------------|------|-------|---------------------|
| 3/32 (2.4 mm)    | ARCFLUX BF 8.7 | Flat & Horizontal |                     | 390  | 27    | 1 - 1 1/4 (25 - 32) |
| 7/64 (2.8 mm)    | ARCFLUX BF 8.7 | Flat & Horizontal |                     | 430  | 28    | 1 - 1 1/2 (25 - 38) |
| 1/8 (3.2 mm)     | ARCFLUX BF 8.7 | Flat & Horizontal |                     | 475  | 29    | 1 - 1 1/2 (25 - 38) |

\* 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.

## 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.



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.