SelectWear 423-S

Hardsurfacing / Flux Shielded / Submerged Arc

PRODUCT DATA SHEET

FEATURES

- Deposits a martensitic stainless steel alloy containing nickel and molybdenum designed for surfacing with the submerged arc process
- The deposit has improved resistance to thermal fatigue and corrosion compared to a 420 alloy
- A neutral flux should be used
- Multiple layers can be deposited with proper welding procedure
- Machinable with carbide tools
- Will not cross crack
- Applications include: Caster Rolls

DIAMETERS [in [mm]]

1/8 (3.2)

POSITIONS

FLUX

Neutral flux recommended

POLARITY

Direct Current Electrode Positive (DCEP)

HARDNESS

42 - 46 HRC

TYPICAL WELD DEPOSIT CHEMISTRY [WT%]

Flux	C	Cr	Fe	Mn	Mo	Nb	Ni	Si	V
Neutral Flux	0.12	12.5	Balance	1.9	1.0	0.2	2.2	0.7	0.2

Chemistry results from a 3 layer pad welded with neutral flux

RECOMMENDED WELDING PARAMETERS **

Diameter in (mm)	Flux	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
1/8 (3.2 mm)	N/A	Flat & Horizontal	120 (3.0)	500	32	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.*

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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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