

SelectWear 52W-S

Hardsurfacing / Flux Shielded / Submerged Arc

PRODUCT DATA SHEET

FEATURES

- Deposits a martensitic alloy similar in composition to an H-12 tool steel
- May be used in hot wear applications up to 1100F
- Very good in highly compressive situations
- Chemistry: Fe-Cr-W-Mo-C
- Multiple layers are possible with proper welding procedure
- Machinable with carbide tools
- Will not cross crack
- Applications include: Steel mill edger rolls, pinch rolls, work rolls, leveler rolls, blast furnace bell seat areas, forging dies, bucket pins

DIAMETERS (in [mm])

0.045 (1.2), 1/16 (1.6), 3/32 (2.4), 7/64 (2.8), 1/8 (3.2)

POSITIONS



FLUX

ArcFlux BF-8.7

POLARITY

Direct Current Electrode Positive (DCEP)

HARDNESS

49 - 54 (4 layers) HRC

RECOMMENDED WELDING PARAMETERS **

Diameter in (mm)	Flux	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
0.045 (1.2 mm)	N/A	Flat & Horizontal	420 (10.7)	270	28	3/4 - 1 (19 - 25)
1/16 (1.6 mm)	N/A	Flat & Horizontal	350 (8.9)	300	28.5	3/4 - 1 (19 - 25)
3/32 (2.4 mm)	N/A	Flat & Horizontal	150 (3.8)	350	29	1 - 1 1/2 (25 - 38)
7/64 (2.8 mm)	N/A	Flat & Horizontal	120 (3.0)	400	29.5	1 - 1 1/2 (25 - 38)
1/8 (3.2 mm)	N/A	Flat & Horizontal	90 (2.3)	450	30	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.



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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