

SelectWear 600TIC-FCO

Hardsurfacing / Self Shielded / Flux Cored

PRODUCT DATA SHEET

FEATURES

- SelectWear 600TIC deposits a high volume fraction of complex carbides (primarily titanium carbides) in an austenitic/martensitic matrix.
- It has high abrasion resistance and excellent resistance to impact
- It is well suited for applications involving extreme wear under high pressure
- SelectWear 600TIC displays superb operability and slag release compared to other titanium carbide bearing hardfacing deposits.
- Applications include: Grinding/pulverizing rolls and table segments, roller presses, dredge pump shells, and rock crushing hammers

DIAMETERS (in [mm])

0.045 (1.2), 0.052 (1.3), 1/16 (1.6), 5/64 (2.0), 3/32 (2.4), 7/64 (2.8), 1/8 (3.2)

POSITIONS



SHIELDING GAS

N/A

POLARITY

Direct Current Electrode Positive (DCEP)

HARDNESS

Hardness: 38-57 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)	N/A	Flat & Horizontal	400 (10.2)	250	25	3/4 - 1 (19 - 25)
0.052 (1.3 mm)	N/A	Flat & Horizontal	325 (8.3)	275	25	3/4 - 1 (19 - 25)
1/16 (1.6 mm)	N/A	Flat & Horizontal	260 (6.6)	300	26	3/4 - 1 1/4 (19 - 32)
5/64 (2.0 mm)	N/A	Flat & Horizontal	225 (5.7)	325	27	3/4 - 1 1/4 (19 - 32)
3/32 (2.4 mm)	N/A	Flat & Horizontal	190 (4.8)	375	27	1 - 1 1/2 (25 - 38)
7/64 (2.8 mm)	N/A	Flat & Horizontal	160 (4.1)	425	28	1 1/4 - 1 3/4 (32 - 44)
1/8 (3.2 mm)	N/A	Flat & Horizontal	115 (2.9)	500	28	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.



Revision: 1/17/2025

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.

600 Enterprise Drive, P.O. Box 259, Fort Loramie, Ohio 45845-0259 • 800-341-5215 • www.Select-Arc.com