

# SelectWear 61GV-FCG

Hardsurfacing / Gas Shielded / Flux Cored

PRODUCT DATA SHEET

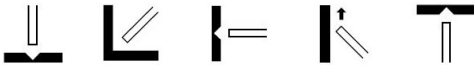
## FEATURES

- A gas shielded, all position, flux cored wire designed for general purpose hardfacing
- Offers exceptionally high hardness without cross check cracking
- Good balance between impact resistance and abrasion resistance
- Excellent choice for components that are required to maintain a sharp edge
- Can be deposited in multiple layers with proper welding procedure
- Applications include: Debarking knives, agricultural tillage, chisel plows, dredge components, earthmoving bucket lips and teeth, extruder screws, repairing worn areas on AR plate

## DIAMETERS (in [mm])

0.045 (1.2), 0.052 (1.3), 1/16 (1.6)

## POSITIONS



## SHIELDING GAS

100% CO<sub>2</sub>, 75% Ar / 25% CO<sub>2</sub>

Flow Rate: 40 - 50 CFH

## POLARITY

Direct Current Electrode Positive (DCEP)

## HARDNESS

3 layers: 57 - 62 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)	75% Ar/25% CO <sub>2</sub>	All Positions	305 (7.7)	190	25	3/4 - 1 (19 - 25)
		Flat & Horizontal	450 (11.4)	250	27	3/4 - 1 (19 - 25)
0.052 (1.3 mm)	75% Ar/25% CO <sub>2</sub>	All Positions	245 (6.2)	200	25	3/4 - 1 1/4 (19 - 32)
		Flat & Horizontal	440 (11.2)	300	27	3/4 - 1 1/4 (19 - 32)
1/16 (1.6 mm)	75% Ar/25% CO <sub>2</sub>	All Positions	175 (4.4)	200	25	3/4 - 1 1/4 (19 - 32)
		Flat & Horizontal	350 (8.9)	350	28	3/4 - 1 1/4 (19 - 32)

\* 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.

For Welding in 100% CO<sub>2</sub>, increase by 1 - 1.5 volts

## 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.

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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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