

SelectWear 63-MCO

Hardsurfacing / Self Shielded / Metal Cored

PRODUCT DATA SHEET

FEATURES

- Deposits primary chromium carbides and secondary columbium carbides in a martensitic matrix
- Wear life is increase by 33% over standard chromium carbide alloys
- Will retain hardness and wear resistance into the 1200-1400F range
- Slightly improved abrasion resistance and reduced impact resistance compared to chromium carbide bearing hardfacing products
- Maximum of 2 layers is recommended
- Applications include: Grinding/pulverizing rolls and table segments, wear plates, clad pipe, fan and mixer blades

DIAMETERS (in [mm])

1/16 (1.6), 5/64 (2.0), 7/64 (2.8), 1/8 (3.2)

POSITIONS



SHIELDING GAS

N/A

POLARITY

Direct Current Electrode Positive (DCEP)

HARDNESS

2 layers: 60 - 63 HRC

RECOMMENDED WELDING PARAMETERS **

Diameter in (mm)	Shielding Gas	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
1/16 (1.6 mm)	N/A	Flat & Horizontal	250 (6.4)	300	27	3/4 - 1 1/4 (19 - 32)
5/64 (2.0 mm)	N/A	Flat & Horizontal	220 (5.6)	335	28	3/4 - 1 1/4 (19 - 32)
7/64 (2.8 mm)	N/A	Flat & Horizontal	160 (4.1)	470	28	1 1/4 - 1 3/4 (32 - 44)
1/8 (3.2 mm)	N/A	Flat & Horizontal	120 (3.0)	500	29	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.

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.