

SelectWear BU-FCG

Hardsurfacing / Gas Shielded / Hardfacing

PRODUCT DATA SHEET

FEATURES

- Deposits a low alloy steel with good compressive strength designed as either an underlay for further hardfacing, or as the final layer for low stress metal-to-metal wear applications
- To be used on carbon and low alloy steels
- Notable for good resistance to compressive loads
- Unlimited layers can be deposited with proper welding procedure
- Applications Include: Rolls, shafts, wheels (mine cars, cranes, etc.), drums, pulleys, steel hammers, gear teeth, shovel parts

DIAMETERS (in [mm])

0.035 (0.9), 0.045 (1.2), 1/16 (1.6), 5/64 (2.0), 3/32 (2.4), 7/64 (2.8), 1/8 (3.2)

POSITIONS



SHIELDING GAS

100% CO₂, 75% Ar / 25% CO₂

Flow Rate: 40 - 50 CFH

POLARITY

Direct Current Electrode Positive (DCEP)

HARDNESS

3 layers: 28 - 38 HRC

RECOMMENDED WELDING PARAMETERS **

Diameter in (mm)	Shielding Gas	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
0.035 (0.9 mm)	75% Ar/25% CO ₂	Flat & Horizontal	400 (10.2)	230	26	1/2 - 1 (13 - 25)
0.045 (1.2 mm)	75% Ar/25% CO ₂	Flat & Horizontal	375 (9.5)	250	27	3/4 - 1 (19 - 25)
1/16 (1.6 mm)	75% Ar/25% CO ₂	Flat & Horizontal	275 (7.0)	300	28	3/4 - 1 1/4 (19 - 32)
5/64 (2.0 mm)	75% Ar/25% CO ₂	Flat & Horizontal	235 (6.0)	325	28	3/4 - 1 1/4 (19 - 32)
3/32 (2.4 mm)	75% Ar/25% CO ₂	Flat & Horizontal	190 (4.8)	375	29	1 - 1 1/2 (25 - 38)
7/64 (2.8 mm)	75% Ar/25% CO ₂	Flat & Horizontal	165 (4.2)	400	29	1 1/4 - 1 3/4 (32 - 44)
1/8 (3.2 mm)	75% Ar/25% CO ₂	Flat & Horizontal	125 (3.2)	475	30	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.

For Welding in 100% CO₂, 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.

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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