

SelectWear BU-S

Hardsurfacing / Flux Shielded / Submerged Arc

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
- Unlimited layers can be deposited with proper welding procedure
- Applications include: Continuous rolls, shafts, wheels (mine cars, cranes, etc.), pulleys, cast steel wear parts
- The softest of our submerged arc build-up products (BU24-S and BU30-S being the other options)

DIAMETERS (in (mm))

3/32 (2.4), 7/64 (2.8), 1/8 (3.2), 5/32 (4.0)

POSITIONS



FLUX

Neutral flux such as ARCFLUX BF-8.7

POLARITY

Direct Current Electrode Positive (DCEP)

HARDNESS

3 layers: 19 - 24 HRC

RECOMMENDED WELDING PARAMETERS **

Diameter in (mm)	Flux	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
3/32 (2.4 mm)	ARCFLUX BF 8.7	Flat & Horizontal	165 (4.2)	400	27	1 - 1 1/2 (25 - 38)
7/64 (2.8 mm)	ARCFLUX BF 8.7	Flat & Horizontal	140 (3.6)	460	28	1 - 1 1/2 (25 - 38)
1/8 (3.2 mm)	ARCFLUX BF 8.7	Flat & Horizontal	115 (2.9)	500	29	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.

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.