

SelectWear BUGV-FCG

Hardsurfacing / Gas Shielded / Hardfacing

PRODUCT DATA SHEET

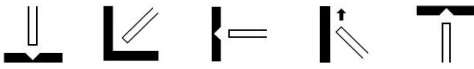
FEATURES

- All position electrode intended to deposit a low alloy steel which can be used as either an underlay for further hardfacing, or as the final layer for low stress metal-to-metal wear applications
- Notable for having 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])

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

POSITIONS



SHIELDING GAS

100% CO₂, 75% Ar / 25% CO₂

Flow Rate: 40 - 50 CFM

POLARITY

Direct Current Electrode Positive (DCEP)

HARDNESS

3 layers: 28 - 33 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 ₂	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 ₂	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 ₂	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

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.

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: 10/3/2022

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