

SelectWear 65-MCO

Hardsurfacing / Self Shielded / Metal Cored

PRODUCT DATA SHEET

FEATURES

- Deposits a high density of primary chromium carbides with multiple secondary carbides
- Specially designed for one or two layer deposits exposed to high temperature (up to 1500F) environments
- Exhibits excellent abrasion resistance and mild impact resistance
- Maximum of 2 layers recommended
- Applications include: Clad wear plate, slurry pipe, cement furnace components, sinter plant parts, fan & 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: 59 - 65 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

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.