



SelectWear 44

Description

SelectWear 44 produces a deposit of chromium carbides in a semi-austenitic matrix. The deposit has what is considered a “medium” level of carbides so it can withstand more impact than “high” carbide deposits. It has good impact and wear resistance. The weld deposit may cross crack, especially in a multi-layer deposit. SelectWear 44 is machinable by grinding only.

Alloy Group

Medium Alloy Carbide Steel

Applications

Designed for metal-to-earth wear resistance: Dredge pump shells and components, crusher rolls, gyratory cones and mantles

Deposit Properties

- Chemistry: Fe-Cr-Mo-C
- Hardness (3 layers): Rc42-45

Weld Parameters

44-MCO - Open arc metal cored wire

<u>Diameter</u>	<u>Polarity</u>	<u>Current (amps)</u>	<u>Voltage</u>	<u>ESO</u>
.045"	DCRP	150-200	24-29	½"-1"
1/16"	DCRP	200-250	26-30	¾"-1¼"
7/64"	DCRP	350-500	26-31	1¼"-1¾"
1/8"	DCRP	400-550	27-32	1¼"-1¾"

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Notice: 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. Select-Arc disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.