

SelectWear 60HC

Description

SelectWear 60HC deposits an alloy with a high density of primary chromium carbides in an iron matrix. It is the most economical choice for high wear applications. Abrasion resistance is high, with moderate impact resistance. **SelectWear 60HC** can be utilized in hot wear applications up to 1100°F. Deposits will cross crack to relieve stresses.

Alloy Group

Chromium Carbide

Applications

Designed for metal-to-earth wear resistance: Grinding/pulverizing rolls and table segments, wear plates, clad pipe, dredge pump shells and related components, hammers

Deposit Properties

- Chemistry: Fe-Cr-C
- Hardness (2 layers): Rc58-62
- Not machinable
- Deposits will cross crack

Recommended Welding Parameters

<u>Diameter</u>	<u>Polarity</u>	<u>Current (amps)</u>	<u>Voltage</u>	<u>ESO</u>
60HC-MCO - Open arc, metal cored wire				
.045"	DCEP	150-200	23-27	½"-1"
1/16"	DCEP	200-270	24-28	¾"-1¼"
5/64"	DCEP	220-350	24-29	¾"-1¼"
3/32"	DCEP	230-375	26-30	¾"-1¼"
7/64"	DCEP	350-450	27-31	1¼"-1¾"
1/8"	DCEP	450-650	29-34	1¼"-1¾"
60HC-MCG - Gas shielded, metal cored wire (Ar-2% O₂ or Ar-CO₂ mixtures)				
.045"	DCRP	180-300	27-33	½"-1"
1/16"	DCRP	240-450	26-35	¾"-1¼"
7/64"	DCRP	350-500	27-35	1¼"-1¾"
1/8"	DCRP	400-650	29-36	1¼"-1¾"

Note: Listed parameters are for Ar-25% CO₂ shielding. Lower voltage for higher argon levels.

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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.