

## SelectWear BU

### Description

**SelectWear BU** is a low alloy steel wire designed for buildup on carbon and low alloy steels. It provides a tough underlayment upon which subsequent hardfacing layers may be placed. It may also be used as the final hardfacing layer where metal to metal wear is non-severe. The deposit is readily machinable with excellent compressive strength and resistance to cracking. Buildup thickness is generally unlimited with proper welding procedures. This wire is not designed for joining applications.

### Alloy Group

Low Alloy Steel

### Applications

Designed for buildup applications: Rolls, shafts, wheels, drums, pulleys, steel hammers, gear teeth, shovel parts

### Deposit Properties

- Chemistry: Fe-Mn-Cr
- Hardness (4 layer): Rc25-35
- Machinable
- Good crack resistance

### Recommended Welding Parameters

#### BU-FCG - Gas shielded flux cored wire (CO<sub>2</sub> or Ar-25% CO<sub>2</sub>)

<u>Diameter</u>	<u>Polarity</u>	<u>Current (amps)</u>	<u>Voltage</u>	<u>ESO</u>
.035"	DCRP	120-220	22-26	½-¾"
.045"	DCRP	150-280	24-29	½-1"
1/16"	DCRP	180-325	26-30	¾-1¼"
5/64"	DCRP	240-400	26-32	¾-1¼"
3/32"	DCRP	300-475	26-33	1-1¼"
7/64"	DCRP	350-500	27-35	1¼-1¾"
1/8"	DCRP	400-650	29-36	1¼-1¾"

*Note: Listed parameters are for CO<sub>2</sub> shielding. Lower by one volt for Ar-25% CO<sub>2</sub>.*

#### BU-FCO - Open arc, flux cored wire

.045"	DCRP	175-300	23-28	½-1"
1/16"	DCRP	225-325	23-30	¾-1"
5/64"	DCRP	250-375	27-31	¾-1¼"
7/64"	DCRP	350-500	26-31	1¼-1¾"
1/8"	DCRP	400-550	27-32	1¼-1¾"

#### BU-MCG - Gas shielded metal cored wire (Ar-2% O<sub>2</sub> or Ar-CO<sub>2</sub> mixtures)

.035"	DCRP	150-240	25-33	½-¾"
.045"	DCRP	180-300	27-33	½-1"
1/16"	DCRP	240-450	26-35	¾-1¼"

*Note: Listed parameters are for Ar-25% CO<sub>2</sub> shielding. Lower voltage for higher argon levels.*

#### BU-S - For submerged arc welding is also available in various diameters

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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.