

Metal Cored Wire

MXC 815M

AWS A5.28 E80C-G / AWS A5.28M E55C-G
JIS Z 3313 T55J6T15-1MA-H5
ISO 17632-A-T 50 6 M M21 1

Description and Applications:

- MXC 815M is a composite metal cored wire designed for single and multipass welding.
- It is a mixed gas shielded wire with low smoke, low spatter, low slag components, and extremely smooth operator appeal.
- The composite metal core and spray transfer of MXC 815M, deposition rates in excess of 15 pounds per hour and deposition efficiencies of 95 percent or greater can be achieved at higher current condition.
- It is specifically designed for welding of heavy weldments requiring high quality, high impact with low diffusible hydrogen.

Guideline in Usage

- The diameters up to 1.6mm are capable of being welded out-of-position.
- Base metal should be preheated.
- Multiple pass welds can be made without deslagging between passes.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	P	S	Ni	Cr	Mo	Fe
0.06	0.64	1.38	0.010	0.007	0.37	0.04	0.01	Bal.

Typical mechanical properties of all-weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-62°C) J
630	673	28	98

Welding parameters

Diameter (mm)	1.2	1.6
Current	DC+	DC+
Amperage	100 ~ 280	180 ~ 350
Voltage	19 ~ 28	26 ~ 32
Wire Extension	13 ~ 20 mm	15 ~ 25 mm
Shielding Gas	80% Ar / 20% CO ₂	80% Ar / 20% CO ₂

Goodweld Corporation
No.99, Huangong Rd. Yongkang Tainan, Taiwan
Phone: 886-6-2331003 Fax: 886-6-2333213
All Right Reserved

GOOD
GOODWELD
www.goodweld.com.tw