

Metal Cored Wire

MXC760Ni

AWS A5.18M E49C-6M/AWS A5.18 E70C-6M
JIS Z 3313 T49J6T15-1MAH5
ISO 17632-A-T 42 6 M M21 1 H5

Product Features:

- MXC 760Ni 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 760Ni, 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.
- Automatic or robotic welding, Structural steel, Storage vessels, Railcar, Earthmoving equipment.

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
0.05	0.49	1.32	0.011	0.007	0.38	0.01	0.01	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact Value		
			(-40°C) J	(-50°C) J	(-62°C) J
528	595	26.8	145	129	103

Size (mm) & recommended welding parameters

Diameter / Length	0.9mm	1.2mm	1.6mm
Polarity	DC+	DC+	DC+
Amperage(A)	90~200	100~280	180~350
Voltage	17~25	19~28	26~32
Wire Extension	10-17mm	13-20mm	15-25mm
Shielding gas	80% Ar/ 20%CO ₂	80% Ar/ 20%CO ₂	80% Ar/ 20%CO ₂

Note:



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