

# Low Alloy Steel Metal Cored Wire

## MXC M91

AWS A5.28 E90C-G / A5.28M E62C-G  
ISO 17634-A-T Z R M 1

### Product Features:

MXC M91 is a composite metal cored wire designed for single and multipass welding of low alloy steels resisted elevated temperature service up to 600°C. The arc is smooth with less spatters. Due to the high level of iron powder and low slag components, the deposited efficiency is higher than the same class solid wire. The forehand welding position is suggested.

It's suitable for welding primarily for boiler superheater tubing, heat exchanger, piping and pressure vessels in oil refineries and power plant.

### Guideline in Usage:

- The diameters up to 1.6mm are capable of being welded out-of-position.
- Base metal should be preheated by 260 °C.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Ni	Mo	Cr	Nb	V	Cu	Fe
0.09	0.39	1.15	0.33	1.13	10.27	0.05	0.23	0.06	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %	Post Weld Heat Treatment °C x 2hr
789	852	20.2	760

Size (mm) & recommended welding parameters

Diameter / Length	1.2mm	1.6mm
Polarity	DCEP	DCEP
Amperage(A)	120~280	180~330
Voltage	24~30	26~31
Wire Extension	15-30mm	20-30mm
Shielding gas	80%Ar+20%CO <sub>2</sub>	80%Ar+20%CO <sub>2</sub>

### Note:

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