

# Hardfacing & Wear Resistant Flux Cored wire

## MXW MANG 1

### Product Features:

- Work hardening type flux cored arc welding wire, austenite structure weld metal.
- Suitable for buildup and repair welding of Mn steel.
- High toughness weld metal to get very fast hardening on high impact working condition.

### Applications:

- Suitable for repair welding of coned mining crusher, hammering crusher, impactor bars, rail frogs and crossings.

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

C	Si	Mn	Cr	Ni
0.71	0.05	14.7	4.32	3.24

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	machining	Flame Cutting	Welding layer	Hard facing stress crack	Tensile Strength N/mm <sup>2</sup>	Yield Strength N/mm <sup>2</sup>	Elongation %	Hardness HRC	
									As Welded	work hardening
normal	high	No good	Not Available	2 or more	Non	844	562	32	20	52

Size & recommended welding parameters

Diameter	1.2mm	1.6mm
Polarity	DC+	DC+
Ampere	150~230	180~340
Voltage	25~33	26~35
Wire extension	15~30mm	15~30mm
Shielding Gas	Self Shield (no gas shield ) / CO <sub>2</sub> or Mixed Gas	Self Shield (no gas shield ) / CO <sub>2</sub> or Mixed Gas

### Note:

- All values listed on the table obtained from non-gas shielded welding test.

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