

Strong impact and abrasion resistant

MXW MANG 3

Product Features:

- Work hardening type flux cored arc welding wire.
- Suitable for buildup and repair welding of Mn steel.
- High toughness weld metal to get very fast hardening on high impact 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
0.29	0.07	16.4	17.1	0.98

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	machining	Flame Cutting	Welding layer	Hardfacing stress crack	Tensile Strength N/mm ²	Yield Strength N/mm ²	Elongation %	Hardness HRC	
									As Welded	work hardening
normal	high	No good	Not Available	2 or more	yes	834	565	40	19	53

Size & recommended welding parameters

Diameter	2.4mm	2.8mm
Polarity	DC+	DC+
Ampere	250~360	280~400
Voltage	26~36	28~38
Wire extension	30~45mm	30~45mm
Shielding Gas	Self Shield (no gas shield)	Self Shield (no gas shield)

Note:

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

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