

Hardfacing and Wear Resistant FCW

MXW BU-O

Product Features:

- Self or gas shield hardfacing flux cored arc welding wire.
- Good for impact and mild abrasion resistances.
- High welding performance, suitable for flat position.
- Available for buffer layer.

Applications:

- Suitable for repair welding of worn out machine parts such as gear transmitter, shaft, pump, wheel shaft, coupler and rails, etc.

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

C	Si	Mn	Cr	Mo
0.08	0.20	1.01	0.82	0.16

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	Adhesive Abrasion Resistance	Machining Ability	Welding layer	Hard facing stress crack	Hardness HRC
Poor	Excellent	Good	Easy	2 or more	Non	27

Size & recommended welding parameters

Diameter	1.2mm	1.6mm
Polarity	DC+	DC+
Ampere	150~320	180~340
Voltage	25~33	26~35
Wire extension	15~30mm	15~30mm
Shielding Gas	Self Shield (no gas shield) / CO ₂ or Mixed Gas	Self Shield (no gas shield) / CO ₂ or Mixed Gas

Note:

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

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