

Buffer layer and welding repairs

MXW K104-S

Product Features:

- Submerged arc welding wire to combine with neutral flux GNF50, low carbon, low alloy content martensite structure weld metal.
- Easy slag removal.
- Available for overlay first buffer layer.
- Good for impact and elastic fatigue resistance.
- Good for repair welding of workpiece subjected to low abrasion and high impact condition.

Applications:

- Repair welding for buffer layer of fly wheel (idler) and rollers.
- Hardfacing repair welding of tract rails, link, journal, chain link, etc.

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

C	Si	Mn	Cr
0.08	0.60	1.80	1.1

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	Machining	Hard facing stress crack	Hardness HRC
Inferior	Excellent	Excellent, available for flame cutting	Non	24

Size & recommended welding parameters

Diameter	2.4mm	2.8mm	3.2mm
Polarity	DC+	DC+	DC+
Ampere	250~360	280~400	290~450
Voltage	26~36	28~38	29~40
Wire extension	25~35mm	25~35mm	25~35mm
Shielding Gas	FLUX GNF50		

Note: