

Hardfacing and wear Resistant FCW

MXW AA-O

Metal to metal abrasion resistant

Product Features:

- AA-O is flux cored self-shielded hardfacing wire for semi-automatic welding.
- Provide a tough, machinable build up deposit on carbon steel and low alloy steel base metal, and ideal for repairing worn parts, which need more wear resistance.
- A preheat and interpass temperature of 100~200Deg. C is suitable to prevent cracking, especially on heavily retrained parts.

Applications:

- Gears, shafts, trunnions, dredge pumps, bulldozer

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

C	Si	Mn	Cr	Mo
0.12	0.50	1.40	1.30	0.18

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	Adhesive Abrasion Resistance	Machining	Thickness	deposit cross check	Hardness HRC
Fair	Good	Good	Easy	Unlimited (with proper procedures)	No	31~39

Size & recommended welding parameters

Diameter	1.2mm	1.6mm
Polarity	DCRP	DCRP
Ampere	150~260	175~320
Voltage	22~30	24~32
Wire extension	12~25mm	18~30mm
Shielding Gas	Self Shied	Self Shield

Note:

- 3 Layer hardness on 1020 steel.

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