

Hardfacing and wear Resistant FCW

MXW BB-G

Product Features:

- Gas shield hardfacing flux cored arc welding wire.
- Good for severe impact and mild abrasion resistance.
- High welding performance, suitable for all positions.
- Available for workpiece subjected to high compression stress.

Applications:

- Suitable for repair welding of worn out machine parts such as gear transmitter, fly wheel, chain block, shaft, caterpillar band, bog bucket, chain link, shovel and cutting tools, etc.

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

C	Si	Mn	Cr	Mo
0.17	0.52	1.17	2.02	0.63

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	Adhesive Abrasion Resistance	Machining	Welding layer	Hard facing stress crack	Hardness HRC
Low	Good	Excellent	Easy	3	Non	44

Size & recommended welding parameters

Diameter	1.2mm	1.6mm
Polarity	DC+	DC+
Ampere	150~320	180~340
Voltage	25~33	26~35
Wire extension	15~25mm	15~25mm
Shielding Gas	CO ₂ or Mixed Gas	CO ₂ or Mixed Gas

Note:

- All values listed on the table obtained from CO₂ gas shielded welding test.

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