

Hardfacing Flux Cored wire

MXW 102-G

Product Features:

- Gas shield flux cored wire for repair welding of hot work tool steel.
- Good for high stress abrasion, heat fatigue and sluggish abrasion resistance.

Applications:

- Suitable for repair welding of worn out machine parts subjected to high compression stress, high impact and moderate abrasion condition and repair welding of tool steel.
- Hardfacing repair welding on carbon and low alloy steel machine parts.
- Suitable for hardfacing repair welding of tractors, overhead crane rollers, gears, crane fly wheels and various rollers, etc.

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

C	Si	Mn	Cr	Mo	W	V
0.33	0.28	1.54	7.78	1.58	1.09	0.38

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	Machining	Welding layer	Hardfacing stress crack	Hardness HRC
Medium	Good	Medium	3	Non	54

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	80%Ar+20%CO ₂	80%Ar+20%CO ₂

Note:

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