

Hardfacing & Wear Resistant FCW

MXW DD-G

Metal to Sand Abrasion Resistant

Product Features:

- High welding performance for all positions.
- Good for impact and abrasion resistance.
- Available for workpiece subjected to metal-to-metal or metal-to-soil abrasion.

Applications:

- Suitable for pump axle sleeve, cement agitator, scouring cutter, digging knife top parts and agitating auger blades and agricultural shovel, etc.

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

| C | Si | Mn | Cr | Mo |
|------|-----|------|------|------|
| 0.47 | 0.6 | 1.58 | 5.77 | 0.72 |

Typical characteristics of weld metal

| Abrasion Resistance | Impact Resistance | Adhesive Abrasion Resistance | Machining | Welding layer | Hard facing stress crack | Hardness HRC |
|---------------------|-------------------|------------------------------|------------|---------------|--------------------------|--------------|
| Good | Good | Good | Grind only | 3 | Non | 57 |

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 or CO ₂ | 80%Ar+20%CO ₂ or CO ₂ |

Note:

Goodweld Corporation
No.99, Huangong Rd. Yongkang Tainan, Taiwan
Phone: 886-6-2331003 Fax: 886-6-2333213
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www.goodweld.com.tw