

Hardfacing & Wear Resistant Flux Cored Wire

MXW 969-G

Product Features:

- Self-hardening martensite structure weld metal.
- Good for high stress abrasion, heat fatigue and sluggish 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
0.64	1.27	1.49	6.26	0.69

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	Welding layer	Hard facing stress crack	Hardness HRC
Good	Good	3	Non	58

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%CO2	80%Ar + 20%CO2

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