

# Hardfacing and wear Resistant FCW

**MXW BB-O**

Metal to metal abrasion resistant

## Product Features:

- MXW BB-O is a flux cored open-arc wire designed specifically for the rebuilding of carbon and low steel parts used in application involving metal-to-metal wears.
- Weld ability is excellent and doesn't need any gas to be shielded.
- The alloy has good compressive strength, hardness and wear resistance.

## Applications:

- Crane Wheels, Tractor Rollers, Undercarriage Parts, Shovel Idlers, Chains, Shafts, Gear Teeth.

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

C	Si	Mn	Cr	Mo	Fe
0.22	0.45	1.50	2.40	0.50	Bal.

Deposit Characteristics

Deposit Layers	Impact Resistance	Compressive Strength	Adhesive Abrasion Resistance	Surface Cross Check	Machinability	*Hardness (As Welded)
Multiple (With proper procedures)	Excellent	Good	Good	None	Good	HRC 42-48

Size & recommended welding parameters

Diameter, mm (in.)	1.2 mm	1.6mm	2.4mm
Current	DC+	DC+	DC+
Ampere	150~250	175~350	240~400
Voltage	22~26	24~30	27~33
Wire extension	12~25mm	18~30mm	25~35mm
Shielding Gas	Self Shield	Self Shield	Self Shield

**Note:** Three layer hardness on 1020 steel

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