

Hardfacing Flux Cored Wire

MXW M7-G

Metal to Sand Abrasion Resistant

Product Features:

- Weld metal composition similar to high speed tool steel.
- High hardening tendency, good for impact abrasion and high stress severe wear condition.
- Wear resistance at elevated high temperature $\leq 540^{\circ}\text{C}$.
- Martensite structure weld metal contains many different kinds of micro carbide.
- Repair welding of workpiece subjected to high stress condition.

Applications:

- Suitable for hardfacing repair welding of dies, cutters, scraper, drill parts, mill roller, extruding screw and agriculture tools, etc.

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

C	Si	Mn	Cr	Mo	V	W
0.94	0.61	0.42	4.07	9.09	1.95	1.91

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	Adhesive Abrasion Resistance	Machining	Welding layer	Hardness HRC
Good	Good	Excellent	Grind only	3	65

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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