

Metal to sand abrasion resistant

MXW R117

Product Features:

- Self or gas shield type hardfacing flux cored arc welding wire.
- Good for impact and abrasion resistance.
- Small stress relieve crack on weld metal surface.

Applications:

- Suitable for repair welding of worn out machine parts such as coned crusher receivers, mantles, hammer crusher, cane knives and crusher rollers, etc.

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

C	Si	Mn	Cr	Mo
2.53	1.46	1.57	10.86	1.79

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	Welding layer	Hardness HRC
Excellent	Excellent	3	52

Size & recommended welding parameters

Diameter	1.2mm	1.6mm
Polarity	DC+	DC+
Ampere	150~320	180~340
Voltage	25~33	26~35
Wire extension	15~30mm	15~30mm
Shielding Gas	Self Shield (no gas shield) / CO ₂	Self Shield (no gas shield) / CO ₂

Note:

- All values listed on the table obtained from non-gas shielded welding test.