

Hardfacing & wear resistant FCW

MXW R100

Product Features:

- Self or gas shield type hardfacing flux cored arc welding wire.
- High carbon and chromium content in weld metal.
- Good for mild to moderate impact severe abrasion resistance.
- Wear resistance at elevated high temperature $\leq 600^{\circ}\text{C}$.

Applications:

- Suitable for hardfacing repair welding of coal crushers, crusher rollers, agricultural, shovel teeth, augers, hot ash elbows and ventilator screw impellers, etc.

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

C	Si	Mn	Cr	Mo
5.03	1.63	1.59	28.10	0.75

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	High Temperature Abrasion	Machining	Welding layer	Hard facing stress crack	Hardness HRC
Excellent	Low to Medium	600°C	Grind only	2	Yes	60

Size & recommended welding parameters

Diameter	1.2mm	1.6mm	2.4mm	2.8mm
Polarity	DC+	DC+	DC+	DC+
Ampere	150~320	180~340	250~360	280~400
Voltage	25~33	25~35	26~35	26~36
Wire extension	15~30mm	15~30mm	30~45mm	30~45mm
Shielding Gas	Self Shield / CO2	Self Shield / CO2	Self Shield	Self Shield

Note:

- Recommend string bead and vertical downward technique, stress crack length 10~15mm to avoid peeling damage between base and weld metal.
- All values listed on the table obtained from non-gas shielded welding test.

Goodweld Corporation
No.99, Huangong Rd. Yongkang Tainan, Taiwan
Phone: 886-6-2331003 Fax: 886-6-233213
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www.goodweld.com.tw