

Hardfacing & Wear Resistant Flux cored

wire

MXW R101

Severe abrasion Resistant

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 $\cong 600^{\circ}\text{C}$.

Applications:

- Suitable for repair welding of worn out machine parts such as shove teeth, blades, split saw handle, scraper side cutters, cutters, shovel bucket insides and lips, agricultural tools, conveyor screw rods, augers and wood drills, etc.

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

C	Si	Mn	Cr	Others
5.23	1.18	0.74	19.50	0.3

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	High Temperature wear	Machining	Welding layer	Hard facing stress crack	Hardness HRC
Excellent	Low to Medium	600°C	Grind only	2	Yes	61

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:

- Recommend string bead 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: 886-6-2333213
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www.goodweld.com.tw