

Hardfacing & Wear Resistant Flux Cored Wire

MXW R100D

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

Applications:

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

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

C	Si	Mn	Cr	Mo
5.5	0.64	0.85	27.3	0.04

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	High Temperature wear	Machining	Welding layer	Hard facing stress crack	Hardness HRC
Excellent	Low	600°C	Grind only	2	Yes	64

Size & recommended welding parameters

Diameter	1.2mm	1.6mm	2.8mm
Polarity	DC+	DC+	DC+
Ampere	150~320	180~340	280~400
Voltage	25~33	26~35	28~38
Wire extension	15~30mm	15~30mm	30~45mm
Shielding Gas	Self Shield / CO ₂	Self Shield / CO ₂	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.

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