

# Hardfacing & Wear Resistant Flux Cored Wire

## MXW R100SHD

----

### Product Features:

- Self 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 elbow, fork lift and ventilator screw impellers, etc.

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

C	Si	Mn	Cr
5.2	1.0	1.48	36.0

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	63

Size & recommended welding parameters

Diameter	2.8mm
Polarity	DC+
Ampere	280~400
Voltage	28~38
Wire extension	30~45mm
Shielding Gas	Self Shield

### Note:

- Recommend string bead technique, stress crack length 10~15mm to avoid peeling damage between base and weld metal.

Goodweld Corporation

No.99, Huangong Rd. Yongkang Tainan, Taiwan

Phone: 886-6-2331003 Fax: 886-6-2333213

All Right Reserved

**GOOD**  
**GOODWELD**  
[www.goodweld.com.tw](http://www.goodweld.com.tw)