

# Hardfacing FCW - Severe abrasion resistant

## MXW 62-O

### Product Features:

- Self or gas shield type hardfacing flux cored arc welding wire.
- High carbon and chromium content in weld metal.
- Wear resistance at elevated high temperature  $\leq 600^{\circ}\text{C}$ .
- Big volume of carbides spread evenly over all weld metal to get very good abrasion resistance.

### Applications:

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

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

C	Si	Mn	Cr	MO	V
5.5	1.0	1.8	23.0	1.2	3.5

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	Hard facing stress crack	Machining	Welding layer	Hardness HRC
Excellent	Low	Yes	Grind only	2	62

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 / CO2 or Mixed Gas	Self Shield / CO2 or Mixed Gas	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.