

Hardfacing and Wear Resistant Flux Cored Wire

MXW 65-O

Product Features:

- Self or gas shield type hardfacing flux cored arc welding wire.
- Big volume of carbides spread evenly over all weld metal to get very good hardening effect.
- Good for elevated high temperature abrasion, low stress severe abrasion and good corrosion resistance.
- Wear resistance at elevated high temperature $\leq 650^{\circ}\text{C}$.

Applications:

- Steel industry: sinter claw breakers, sieve rakes and hot ash elbows.
- Cement industry: screw rod, coned sintering rollers and high temperature furnace machine parts.
- Mining industry: mud delivery pipe, basket shovel teeth and excavators.

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

C	Si	Mn	Cr	Nb
5.2	1.2	1.8	23.5	6.7

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	Hard facing stress crack	Machining	Welding layer	Hardness HRC
$\leq 650^{\circ}\text{C}$	Low	Yes	Grind only	2	63

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	26~35	26~36	28~38
Wire extension	15~30mm	15~30mm	30~45mm	30~45mm
Shielding Gas	Self Shield / CO ₂	Self Shield / CO ₂	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.