

Hardfacing & Wear Resistant Flux Cored Wire

MXW 66-O

Severe Abrasion Resistant

Product Features:

- Self or gas shield type hardfacing flux cored arc welding wire.
- Chromium carbide and very high V element contained to form a big volume of micro vanadium carbide in weld metal to get very good metal-to-hard soil abrasion resistance.
- Good for elevated high temperature abrasion, low stress severe abrasion and good corrosion resistance.
- Wear resistance at elevated high temperature $\leq 600^{\circ}\text{C}$.

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 excavator.

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

C	Si	Mn	Cr	V
5.5	1.0	1.5	21.0	10.2

Typical characteristics of weld metal

High Temperature Abrasion Resistance	Impact Resistance	Hard facing stress crack	Machining	Welding layer	Hardness HRC
$\leq 600^{\circ}\text{C}$	Low	Yes	Grind only	2	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 and vertical downward technique, stress crack length 10~15mm to avoid peeling damage between base and weld metal.

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