

Severe abrasion resistant

MXW 70-O

Product Features:

- Self 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 excavator.

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

C	Si	Mn	Cr	Nb	V	others
5.5	0.5	0.8	11.2	6.6	6.2	<3.0

Typical characteristics of weld metal

High Temperature Abrasion Resistance	Impact Resistance	Hard facing stress crack	Welding layer	Hardness HRC
$\leq 650^{\circ}\text{C}$	Low	Yes	2	65

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.