

Hardfacing & Wear resistant SAW

MXW K410NiMo-S

Product Features:

- Composite type hardfacing submerged arc welding wire, martensitic structure weld metal.
- Combined with neutral flux.
- Good for crack resistance and easy slag removal.
- Good thermal fatigue, corrosion and abrasion resistance.

Applications:

- Hardfacing repair welding of steel mill roller, heat resistant valve seat and turbine blade.

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

C	Si	Mn	Ni	Cr	Mo
0.04	0.5	1.0	4.1	12.5	0.55

Typical characteristics of weld metal

Abrasion Resistance	Thermal fatigue Resistance	Machining	Welding layer	Hard facing stress crack	Hardness HRC
Excellent	Good	Tungsten Carbide tools available	3	Non	43

Size & recommended welding parameters

Diameter	3.2mm
Polarity	DC+
Ampere	320~400
Voltage	30~36
Wire extension	25~40mm
Flux	Neutral Flux GNF50

Note:

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