

# Hardfacing SAW - High temperature fatigue and corrosion resistant

## MXW K420-S

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### Product Features:

- Composite type hardfacing submerged arc welding wire, martensite structure weld metal.
- Combined with neutral flux.
- Good thermal fatigue, corrosion and abrasion resistance.

### Applications:

- Hardfacing repair welding of steel mill roller and fly wheel.

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

C	Si	Mn	Cr
0.18	0.50	1.2	12.8

Typical characteristics of weld metal

Abrasion Resistance	Thermal fatigue Resistance	Machining	Welding Layer	Hard facing stress crack	Hardness HRC
Good	Excellent	Tungsten Carbide tools can be used	3	Non	47

Size & recommended welding parameters

Diameter	2.4mm	3.2mm
Polarity	DC+	DC+
Ampere	250~360	290~450
Voltage	26~36	29~40
Wire extension	25~35mm	25~35mm
Flux	Neutral Flux GNF50	

**Note:** Pls refer to Weling notes for preheat and inter pass temperature control

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