

MXW BU-O | —

Product Features:

- Self or gas shield hardfacing flux cored arc welding wire.
- Good for impact and mild abrasion resistances.
- High welding performance, suitable for flat position.
- Available for buffer layer.

Applications:

- Suitable for repair welding of worn out machine parts such as gear transmitter, shaft, pump, wheel shaft, coupler and rails, etc.

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

C	Si	Mn	Cr	Mo
0.08	0.19	0.98	0.77	0.16

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	Adhesive Abrasion Resistance	Machining Ability	Welding layer	Hard facing stress crack	Hardness HRC
Poor	Excellent	Good	Easy	2 or more	Non	29.4

Size & recommended welding parameters

Diameter	1.2mm	1.6mm
Polarity	DC+	DC+
Ampere	150~250	175~350
Voltage	22~26	24~28
Wire extension	15~30mm	20~35mm
Shield Gas	Self Shield (no gas shield) / CO ₂ or Mixed Gas	Self Shield (no gas shield) / CO ₂ or Mixed Gas

- © Note: 1. Refer to page D6 welding notes (table 1) for preheat and inter pass temperature control while multiple passes welding.
2. All values listed on table obtained from non-gas shielded welding test.

MXW BU-G | —

Product Features:

- Gas shield hardfacing flux cored arc welding wire.
- Good for impact and mild abrasion resistances.
- High welding performance, suitable for all positions.
- Available for buffer layer.

Applications:

- Suitable for repair welding of worn out machine parts such as gear transmitter, shaft, pump, wheel shaft, coupler and rails, etc.

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

C	Si	Mn	Cr	Mo
0.10	0.50	1.20	1.2	0.30

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	Adhesive Abrasion Resistance	Machining Ability	Welding layer	Hard facing stress crack	Hardness HRC
Inferior	Excellent	Good	Easy	2 or more	Non	24

Size & recommended welding parameters

Diameter	1.2mm	1.6mm
Polarity	DC+	DC+
Ampere	150~250	175~350
Voltage	22~26	24~28
Wire extension	15~25mm	15~25mm
Shield Gas	CO ₂ or Mixed Gas	CO ₂ or Mixed Gas

- © Note: 1. Refer to page D6 welding notes (table 1) for preheat and inter pass temperature control while multiple passes welding.
2. All values listed on table obtained from CO₂ gas shielded welding test.

MXW K104-S | —

Product Features:

- Submerged arc welding wire to combine with neutral flux, low carbon, low alloy content martensite structure weld metal.
- Easy slag removal.
- Available for overlay first buffer layer.
- Good for impact and elastic fatigue resistance.
- Good for repair welding of workpiece subjected to low abrasion and high impact condition.

Applications:

- Repair welding for buffer layer of fly wheel (idler) and rollers.
- Hardfacing repair welding of tract rails, link, journal, chain link, etc.

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

C	Si	Mn	Cr
0.08	0.60	1.8	1.1

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	Machining	Hard facing stress crack	Hardness HRC
Inferior	Excellent	Excellent, available for flame cutting	Non	24

Size & recommended welding parameters

Diameter	2.8mm	3.2mm
Polarity	DC+	DC+
Ampere	280~350	320~400
Voltage	28~32	30~36
Wire extension	20~35mm	25~40mm
Flux	Neutral Flux	Neutral Flux

© Note: Refer to page D6 welding notes (table 1) for preheat and inter pass temperature control.