MXW SUPER BU-G

Product Features:

- Gas shield hardfacing flux cored arc welding wire.
- Good for severe impact and mild abrasion resistance.
- High welding performance, suitable for all positions.
- Available for workpiece subjected to high compression stress.

Applications:

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

Typical chemical composition of all-weld metal (wt%)				
C	Si	Mn	Cr	Mo
0.12	0.44	1.68	1.26	0.30

Typical characteristics of weld metal						
Abrasion Resistance	Impact Resistance	Adhesive Abrasion Resistance	Machining	Welding layer	Hard facing stress crack	Hardness HRC
Low	Good	Good	Easy	2 or more	Non	34

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 CO_2 gas shielded welding test.

MXW BB-G –

Product Features:

- Gas shield hardfacing flux cored arc welding wire.
- Good for severe impact and mild abrasion resistance.
- High welding performance, suitable for all positions.
- Available for workpiece subjected to high compression stress.

Applications:

- Suitable for repair welding of worn out machine parts such as gear transmitter, fly wheel, chain block, shaft, caterpillar band, bog bucket, chain link, shovel and cutting tools, etc.

Typical chemical composition of all-weld metal (wt%)				
C	Si	Mn	Cr	Mo
0.20	0.54	1.18	2.09	0.53

Typical characteristics of weld metal						
Abrasion Resistance	Impact Resistance	Adhesive Abrasion Resistance	Machining	Welding layer	Hard facing stress crack	Hardness HRC
Low	Good	Excellent	Easy	3	Non	44

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 CO_2 gas shielded welding test.

MXW 102-G –

Product Features:

- Gas shield flux cored wire for repair welding of hot work tool steel.
- Good for high stress abrasion, heat fatigue and sluggish abrasion resistance.

Applications:

- Suitable for repair welding of worn out machine parts subjected to high compression stress, high impact and moderate abrasion condition and repair welding of tool steel.
- Hardfacing repair welding on carbon and low alloy steel machine parts.
- Suitable for hardfacing repair welding of tractors, overhead crane rollers, gears, crane fly wheels and various rollers, etc.

Typical chemical composition of all-weld metal (wt%)						
C	Si	Mn	Cr	Mo	W	V
0.29	0.39	1.76	6.8	1.3	1.28	0.2

Typical characteristics of weld metal					
Abrasion Resistance	Impact Resistance	Machining	Welding layer	Hard facing stress crack	Hardness HRC
Medium	Good	Medium	3	Non	52

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	80%Ar + 20%CO_2	80%Ar + 20%CO_2

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

MXW K102-S | –

Product Features:

- Martensite type hardfacing submerged arc welding wire for repair welding of alloy hot work tool steels.
- Combined with neutral flux.
- Available for workpiece subjected to high stress, high impact and moderate abrasion condition.
- Easy slag removal.

Applications:

- Suitable for hardfacing repair welding of tractors, overhead crane rollers, gears, crane fly wheels and various rollers, etc.

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

C	Si	Mn	Cr	Mo	W	V
0.3	1.2	1.2	6.8	1.2	1.2	0.2

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	Machining	Welding layer	Hard facing stress crack	Hardness HRC
Medium	Good	Medium	3	Non	50

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.

MXW K105-S | –

Product Features:

- Low alloy elements contained submerged arc welding wire.
- Combined with neutral flux.
- Available for workpiece subjected to metal-to-metal abrasion.
- Easy slag removal.

Applications:

- Suitable for hardfacing repair welding of tractors, overhead crane rollers, gears, crane fly wheels and various rollers, etc.

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

C	Si	Mn	Cr	Mo	V
0.20	0.7	2.6	2.8	0.6	0.2

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	Welding layer	Hard facing stress crack	Hardness HRC
Medium low	Good	3	Non	45

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.

MXW K107-S –

Product Features:

- Martensite structure type hardfacing submerged arc welding wire for repair welding of alloy hot work tool steels.
- Easy slag removal.
- Available for workpiece subjected to high stress, high impact and mild abrasion condition.

Applications:

- Suitable for hardfacing repair welding of worn out machine parts such as gears, cutter, dies, tools and various rollers, etc.

Typical chemical composition of all-weld metal (wt%)				
C	Si	Mn	Cr	Mo
0.14	0.4	1.8	2.2	0.3

Typical characteristics of weld metal					
Abrasion Resistance	Impact Resistance	Machining	Welding layer	Hard facing stress crack	Hardness HRC
Low	Good	Medium	□	Non	39

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.