MXW R100 | –

Product Features:

- Self or gas shield type hardfacing flux cored arc welding wire.
- High carbon and chromium content in weld metal.
- Good for mild to moderate impact severe abrasion resistance.
- Wear resistance at elevated high temperature ≦ 600°C.

Applications:

- Suitable for hardfacing repair welding of coal crushers, crusher rollers, agricultural, shovel teeth, augers, hot ash elbows and ventilator screw impellers, etc.

Typical chemical composition of all-weld metal (wt%)				
C	Si	Mn	Cr	Mo
4.8	1.5	1.5	26.5	1.0

Typical characteristics of weld metal						
Abrasion Resistance	Impact Resistance	High Temperature Abrasion	Machining	Welding layer	Hard facing stress crack	Hardness HRC
Excellent	Low to Medium	600°C	Grind only	2	Yes	60

Size & recommended welding parameters			
Diameter	1.6mm	2.4mm	2.8mm
Polarity	DC+	DC+	DC+
Ampere	200~350	230~380	300~450
Voltage	26~32	30~35	32~38
Wire extension	20~30mm	20~35mm	25~45mm
Shield Gas	Self Shield / CO_2 or Mixed Gas	Self Shield / CO_2 or Mixed Gas	Self Shield

◎ Note: 1. Recommend string bead and vertical downward technique, stress crack length 10~15mm to avoid peeling damage between base and weld metal.
2. Refer to page D6 welding notes (table 1) for preheat and inter pass temperature control.
3. All values listed on the table obtained from non-gas shielded welding test.

MXW R101 –

Product Features:

- Self or gas shield type hardfacing flux cored arc welding wire.
- High carbon and chromium content in weld metal.
- Good for mild to moderate impact severe abrasion resistance.
- Wear resistance at elevated high temperature ≦ 600°C.

Applications:

- Suitable for repair welding of worn out machine parts such as shove teeth, blades, split saw handle, scraper side cutters, cutters, shovel bucket insides and lips, agricultural tools, conveyor screw rods, augers and wood drills, etc.

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

C	Si	Mn	Cr	Others
5.11	1.26	0.83	19.41	0.3

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	High Temperature wear	Machining	Welding layer	Hard facing stress crack	Hardness HRC
Excellent	Low to Medium	600°C	Grind only	2	Yes	61

Size & recommended welding parameters

Diameter	1.2mm	1.6mm
Polarity	DC+	DC+
Ampere	150~250	175~350
Voltage	24~30	26~32
Wire extension	20~25mm	20~30mm
Shield Gas	Self Shield (no gas shield) / CO_2 or Mixed Gas	Self Shield (no gas shield) / CO_2 or Mixed Gas

◎ Note: 1. Recommend string bead technique, stress crack length 10~15mm to avoid peeling damage between base and weld metal.
2. Refer to page D6 welding notes (table 1) for preheat and inter pass temperature control.
3. All values listed on the table obtained from non-gas shielded welding test.

MXW R100D –

Product Features:

- Self or gas shield type hardfacing flux cored arc welding wire.
- High carbon and chromium content in weld metal.
- Good for mild to moderate impact severe abrasion resistance .
- Wear resistance at elevated high temperature ≦ 600°C.

Applications:

- Suitable for hardfacing repair welding of coal crushers, crusher rollers, agricultural tools, shovel teeth, augers, hot ash elbows and ventilator screw impellers, etc.

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

C	Si	Mn	Cr	Mo
5.5	0.64	0.85	27.3	0.04

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	High Temperature wear	Machining	Welding layer	Hard facing stress crack	Hardness HRC
Excellent	Low	600°C	Grind only	2	Yes	61

Size & recommended welding parameters

Diameter	1.2mm	1.6mm	2.8mm
Polarity	DC+	DC+	DC+
Ampere	150~250	175~350	300~450
Voltage	24~30	26~32	32~38
Wire extension	20~25mm	20~30mm	25~45mm
Shield Gas	Self Shield / CO_2 or Mixed Gas	Self Shield / CO_2 or Mixed Gas	Self Shield

◎ Note: 1. Recommend string bead and vertical downward technique, stress crack length 10~15mm to avoid peeling damage between base and weld metal.
2. Refer to page D6 welding notes (table 1) for preheat and inter pass temperature control.
3. All values listed on the table obtained from non-gas shielded welding test.

MXW R100SHD

Product Features:

- Self shield type hardfacing flux cored arc welding wire.
- High carbon and chromium content in weld metal.
- Good for mild to moderate impact severe abrasion resistance.
- Wear resistance at elevated high temperature ≦ 600°C.

Applications:

- Suitable for hardfacing repair welding of coal crushers, crusher rollers, agricultural tools, shovel teeth, augers, hot ash elbow, fork lift and ventilator screw impellers, etc.

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

C	Si	Mn	Cr
5.2	1.0	1.48	36.0

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	High Temperature wear	Machining	Welding layer	Hard facing stress crack	Hardness HRC
Excellent	Low	600°C	Grind only	2	Yes	62

Size & recommended welding parameters

Diameter	2.8mm
Polarity	DC+
Ampere	300~450
Voltage	32~38
Wire extension	25~45mm
Shield Gas	Self Shield

◎ Note: 1. Recommend string bead technique, stress crack length 10~15mm to avoid peeling damage between base and weld metal.
2. Refer to page D6 welding notes (table 1) for preheat and inter pass temperature control.

MXW 62-O

Product Features:

- Self or gas shield type hardfacing flux cored arc welding wire.
- High carbon and chromium content in weld metal.
- Wear resistance at elevated high temperature ≦ 600°C.
- Big volume of carbides spread evenly over all weld metal to get very good abrasion resistance.

Applications:

- Suitable for hardfacing repair welding of coal crushers, crusher rollers, agricultural tools, shovel teeth, augers, fork lift and ventilator screw impellers, etc.

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

C	Si	Mn	Cr	Mo	V
5.5	1.0	1.8	23.0	1.2	3.5

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	Hard facing stress crack	Machining	Welding layer	Hardness HRC
Excellent	Low	Yes	Grind only	2	62

Size & recommended welding parameters

Diameter	1.2mm	1.6mm	2.8mm
Polarity	DC+	DC+	DC+
Ampere	150~250	175~350	300~450
Voltage	24~30	26~32	32~38
Wire extension	20~25mm	20~30mm	25~40mm
Shield Gas	Self Shield / CO_2 or Mixed Gas	Self Shield / CO_2 or Mixed Gas	Self Shield

◎ Note: 1. Recommend string bead and vertical downward technique, stress crack length 10~15mm to avoid peeling damage between base and weld metal.
2. Refer to page D6 welding notes (table 1) for preheat and inter pass temperature control.
3. All values listed on the table obtained from non-gas shielded welding test.

MXW 63-O –

Product Features:

- Self or gas shield type hardfacing flux cored arc welding wire.
- Good for elevated high temperature abrasion, low stress severe abrasion and corrosion resistance.
- Big volume of carbides spread evenly over all weld metal to get better abrasion resistance than 62-O.
- Wear resistance at elevated high temperature ≦ 816°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	Mo	Nb	W	V
5.2	0.55	0.93	19.22	5.20	5.2	2.0	1.10

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	Hard facing stress crack	Machining	Welding layer	Hardness HRC
Excellent	Low	Yes	Grind only	2	64

Size & recommended welding parameters

Diameter	1.2mm	1.6mm	2.8mm
Polarity	DC+	DC+	DC+
Ampere	150~250	175~350	300~450
Voltage	24~30	26~32	32~38
Wire extension	20~25mm	20~30mm	25~40mm
Shield Gas	Self Shield / CO_2 or Mixed Gas	Self Shield / CO_2 or Mixed Gas	Self Shield

◎ Note: 1. Recommend string bead and vertical downward technique, stress crack length 10~15mm to avoid peeling damage between base and weld metal.
2. Refer to page D6 welding notes (table 1) for preheat and inter pass temperature control.
3. All values listed on the table obtained from non-gas shielded welding test.

MXW 65-O –

Product Features:

- Self or gas 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 ≦ 650°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
5.2	1.2	1.8	23.5	6.7

Typical characteristics of weld metal

Abrasion Resistance	Impact Resistance	Hard facing stress crack	Machining	Welding layer	Hardness HRC
≦ 650˚C	Low	Yes	Grind only	2	63

Size & recommended welding parameters

Diameter	1.2mm	1.6mm	2.8mm
Polarity	DC+	DC+	DC+
Ampere	150~250	175~350	300~450
Voltage	24~30	26~32	32~38
Wire extension	20~25mm	20~30mm	25~40mm
Shield Gas	Self Shield / CO_2 or Mixed Gas	Self Shield / CO_2 or Mixed Gas	Self Shield

◎ Note: 1. Recommend string bead and vertical downward technique, stress crack length 10~15mm to avoid peeling damage between base and weld metal.
2. Refer to page D6 welding notes (table 1) for preheat and inter pass temperature control.
3. All values listed on the table obtained from non-gas shielded welding test.