EXECUTIVE MAX-WEAR

WEAR RESISTANT CORED WIRE

HARDFACING TECHNICAL DATA SHEET

DESCRIPTION

Executive MAX-WEAR is a flux-cored hard surfacing wire that deposits a chrome carbide alloy designed to provide excellent abrasion resistance and withstand moderate impact. It can outlast competitive hard surfacing wires due to its unique microstructure of primary chrome carbides in a eutectic matrix.

Executive MAX-WEAR can be used on mild steel, low alloy steel or manganese steel, with or without shielding gas. The weld deposit is designed to check crack which provides some measure of stress relief and is not detrimental to its wear properties.

APPLICATIONS & FEATURES

Executive MAX-WEAR can be used on severe abrasion applications such as, augers, cone crushers, catalyst piping, tool joints, crusher rolls, bucket teeth and blades, dragline chains, grizzlies, ore chutes, pug mills, paddles and other applications where excellent abrasion and moderate impact resistances are required.

TYPICAL MECHANICAL CHARACTERISTICS

Abrasion Resistance:	Excellent	**Hardness**	**1 layer:**	52-57 HRc
Impact Resistance:	Moderate		**2 layers:**	58-61 HRc
Machinability:	Grind Only		**3 Layers:**	59-65 HRc

TYPICAL WELDING PARAMETERS

Diameter	Voltage	Amperage	Stick Out	Shielding Gas
.045"	20-24	120-210	½" – ¾"	100% CO2 or Ar / CO2 Mixes
1/16"	24-27	210-310	5/8" – 1"	
3/32"	26-30	300-450	1 – 1 ¼"	
7/64"	26-30	350-500	1 ¼" – 1 ½"	

Size	**1/8"**	**5/32"**	**3/16"**
Amps	100-145	125-185	150-220

Deposition rate of 10 to 20 pounds per hour, relative to wire diameter
For open arc usage increase stick out by ¼" – ½", relative to wire diameter

STANDARD PACKAGING

Spools	28-lb plastic spools	**Electrodes**	10-lb tubes in 1/8", 5/32" and 3/16" diameters

CLASSIFICATION

Executive MAX-WEAR is a chromium carbide iron base steel hard-facing alloy.

There is no AWS classification for this wire.