

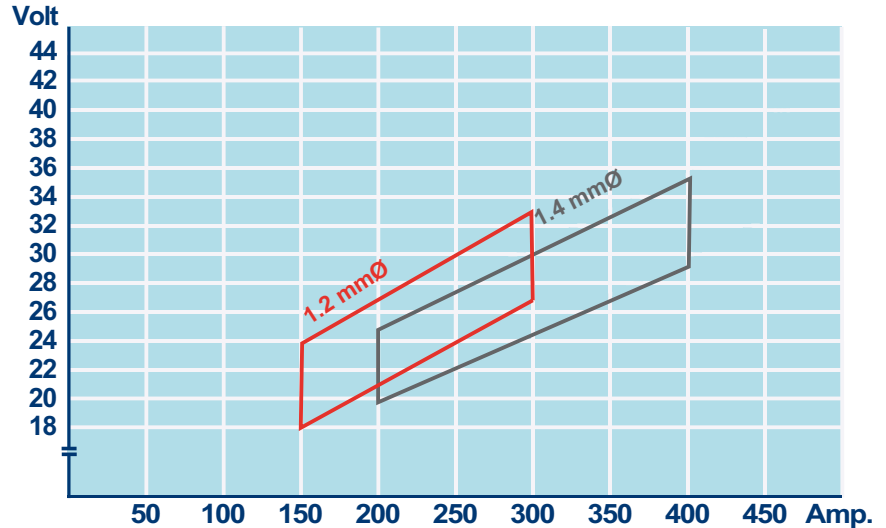
Description and Application

MX-200E is a metal type flux cored wire. This special metal cored wire has been formulated for high speed fillet welding of plate coated with modern inorganic zinc primers, or plate contaminated with rust or mill scale.

MX-200E produces a weld bead totally free from any traces of silicate slag normally associated with the welding of metal cored or solid wires.

This wire is an excellent choice for mechanised welding of horizontal fillets as it meets the requirements of superior wire feeding properties combined with high deposition efficiency and very good resistance to porosity.

Recommended Parameter Range, for flat position



Chemical Analysis (wt.%)

| | C | Si | Mn | P | S | Ni | Cr | Mo | Shielding gas |
|---------|------|------|------|-------|-------|----|----|----|---------------------|
| MX-200E | 0.05 | 0.60 | 1.60 | 0.008 | 0.007 | - | - | - | 100%CO ₂ |

Mechanical Properties

| | R _e (N/mm ²) | R _m (N/mm ²) | A ₅ (%) | CV (J) -30°C | CV (J) -40°C | Shielding gas |
|---------|-------------------------------------|-------------------------------------|--------------------|--------------|--------------|---------------------|
| MX-200E | 540 | 600 | 29 | 100 | 83 | 100%CO ₂ |

Welding Positions

MX-200E
 1.2, 1.4mm



Approvals

| | LR | DNV | BV | GL | ABS | R.M.R.S. | Others |
|---------|-------|---------|---------|-------|---------|----------|--------|
| MX-200E | 4Y40S | IV 40MS | SA4Y40M | 4Y40S | 4Y400SA | 4Y40MS | - |