

## Description and Application

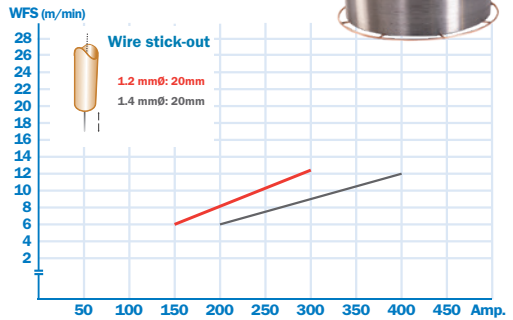
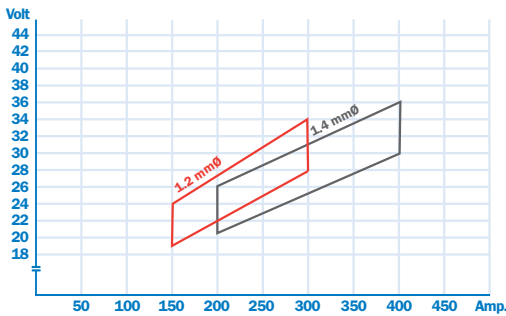
**MX-200E** is a metal type flux cored wire. This special metal cored wire has been formulated for high speed fillet welding of plate coated with modern inorganic zinc primers, or plate contaminated with rust or mill scale.

**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 excellent resistance to porosity. It has found wide acceptance for the fillet welding of stiffeners in the shipbuilding industry.



### Recommended Parameter Range, for flat position



### Typical Chemical Analysis (wt. %)

C	Si	Mn	P	S	Ni	Cr	Mo
0.05	0.60	1.60	0.008	0.007	-	-	-

### Typical Mechanical Properties

	R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	CV(J)-30°C
	540	600	29	100
Guaranty	min.420	500~640	min.20	min.47

Example of Diffusible hydrogen content: 4.3 [ml/100g]

### Welding Positions



### Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
4Y40S H5	IVY40MS H5	SA4Y40M H5	4Y400SA H5	4Y40MS H5	P.R.S.