

MG 262

PREMIUM CAST IRON ELECTRODE FOR MULTI-LAYER WELDS WHERE HIGH STRENGTH AND HIGH DUCTILITY IS ESSENTIAL DCEP (ELECTRODE POSITIVE +) OR AC

GENERAL CHARACTERISTICS:

Outstanding elongation in this graphite coated electrode makes it excellent for welding nodular and gray cast iron when ductile deposits are required. Special bi-metal core wire prevents overheating.

APPLICATIONS:

Use on all weldable grades of cast iron when multi-layer deposits requiring high strength, good ductility and machinability are a must. Excellent for complex castings.

TECHNICAL DATA:

Tensile Strength	80,000 psi (56 kg/mm ²)		
Yield Strength	63,000 psi (44 kg/mm ²)		
Elongation %	24		
Hardness	HB 200		
Current	AC or DC reverse (electrode +)		
Amperage	70-100	90-150	100-180
(in)	3/32	1/8	5/32
(mm)	2.4	3.2	4.0
Specification	similar to AWS A5.15 Class ENiFeMn-CI		

PROCEDURE:

Clean weld area as much as possible. On heavy sections, remove worn, cracked metal, and bevel joint using MG 570 or a grinding wheel. If the weld area is contaminated with oil or grease it may be removed by using a strong oxidizing oxy-acetylene flame to burn it off. On very heavy sections, preheat to approximately 400°F.