

**MG
289W**

METAL CORED MIG WIRE FOR BUILD-UP OR REPAIR OF CAST IRON

DC REVERSE POLARITY (ELECTRODE +)

GENERAL CHARACTERISTICS:

This unique metal cored MIG wire produces dense, strong, crack-resistant welds on all types of weldable cast irons. Especially good for contaminated, old, oil soaked, dirty base metal. Also recommended for joining cast iron to steel.

APPLICATIONS:

Use on sewer pipe, machine bases, transmission or gear housings, sprockets, repair of or build-up on gears, and any repair of cast iron to steel.

TECHNICAL DATA:

Tensile Strength	up to 70,000 psi (483 N/mm ²)	
Hardness	187 Brinell	
Current	DC reverse polarity	
Shielding Gas	98% Argon, 2% Oxygen	
Diameter	(in)	.035	.045
	(mm)	.9	1.2
Amps		150-180	220-250
Volts		26-28	27-29
Stickout		1/2	1/2

PROCEDURE:

Remove foreign materials. Preheat 400°-600°F. Apply weld as stringer beads with a slight side to side motion. Fill all craters and allow to cool slowly.