

MG
310-AC
320-DC

PHOSPHOR (TIN) BRONZE
ELECTRODE FOR APPLICATIONS
SUBJECTED TO FRICTIONAL WEAR

AC OR DC REVERSE (ELECTRODE +)

GENERAL CHARACTERISTICS:

Both AC and DC types have smooth arcs that produce dense, porosity free deposits in all positions with a minimum of spatter. Welds have excellent color match to bronze. Slag is easy to remove.

APPLICATIONS:

Due to the nickel content, the DC electrode deposits are harder and more wear resistant than the AC deposits. The AC electrode should be used when "arc brazing" galvanized sheets or when color match and machining are required after welding. MG-320 DC electrodes are preferred for higher strength joining and cladding of bronzes, brass, steel, and cast steel. Both electrodes offer good resistance to sea water and many other chemicals. Common applications are repair and surfacing of gearwheels, bearings, pumps, impellers, turbines, valve bodies, and defects in new castings.

TECHNICAL DATA:

Tensile Strength	50,000 to 60,000 psi (345 to 414 N/mm ²)	
Yield Strength	20,000 to 35,000 psi (137 to 241 N/mm ²)	
Elongation	approx. 30% to 40%	
Hardness (HB)	80-120	
Current		
	MG-310	AC or DC reverse polarity (electrode+)
	 (on cast iron use DC reverse)
	MG-320	DC reverse polarity (electrode+)
Amperage	100-150	125-190
	(in)	1/8 5/32
	(mm)	3.2 4.0

PROCEDURE:

Bevel edges of heavy sections to form a 45° vee. Preheat is not required. Weld puddle should be clearly visible; maintain a medium arc length. Allow part to partially cool before removing slag.

MESSER 
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