

**MG 505**

**UNIVERSAL ELECTRODE  
FOR WELDING RUSTY  
AND SCALY STEELS  
IN ANY POSITION  
AC OR DC EITHER POLARITY**

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**GENERAL CHARACTERISTICS:**

This is a mild-steel electrode with medium-heavy flux-coating. It is designed for downhand, overhead, and general all position welding. Deep penetration can be made on rusty and scaly steel. Low amperage is required and spatter is very low.

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**APPLICATIONS:**

General welding of all structural steels and mild steel pipe. Also used to weld through painted and galvanized surfaces as well as rusty and scaly surfaces. Ideal for tack welding and general field welding.

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**TECHNICAL DATA:**

Tensile Strength..... up to 83,000 psi (572 N/mm<sup>2</sup>)  
Yield Strength ..... up to 67,000 psi (462 N/mm<sup>2</sup>)  
Elongation ..... approx. 24%  
Current ..... AC or DC either polarity  
Amperage 60-100 100-140 110-190  
(in) 3/32 1/8 5/32  
(mm) 2.4 3.2 4.0  
Deposition Rate: (lbs. per hour) 1.2-2.0 1.9-2.6 2.2-3.7

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**PROCEDURE:**

Remove as much foreign material as practical from the weld area. DC reverse polarity (electrode+) produces deep penetration; DC straight polarity (electrode-) will have limited penetration and a flatter bead. AC prevents arc blow. A medium arc length should be maintained with either stringer or weave beads. Slag is easily removed.