

# MG 506W

## SPECIAL GAS SHIELDED, FLUX-CORED, MILD-STEEL ELECTRODE FOR MAINTENANCE AND REPAIR WELDING DIRTY, RUSTY, AND PAINTED STEELS

### **GENERAL CHARACTERISTICS:**

The special formulation of this gas-shielded, flux-cored wire allows it to be used in many of the same applications as MG 506 coated electrode. Use for single or multipass, flat and horizontal welds on carbon and some low alloy steels where dirt, grease and paint cannot be removed prior to welding. Almost slag-free welds reduce cleanup time and increase deposition rates resulting in overall lower welding time. Designed for the maintenance and repair welder.

### **APPLICATIONS:**

Use to fabricate and repair carbon and low alloy steel, plates, structural components and machinery parts. Excellent for short intermittent welds. Use where proper cleaning of the weld area is impractical or impossible. Designed to make the quick repair where proper cleaning of the weld area is not possible.

### **TECHNICAL DATA:**

Tensile Strength ..... up to 80,000 psi (551 N/mm<sup>2</sup>)  
 Yield Strength ..... up to 68,000 psi (468 N/mm<sup>2</sup>)  
 Elongation % ..... approx. 26  
 Current ..... DCEP(electrode+)  
 Diameters Available ..... .035", .045" and .052"  
 Spool Sizes Available ..... 4lb., 10lb. and 25lb.  
 Shielding Gas ..... 75% Ar 25% CO<sup>2</sup> or 100% CO<sup>2</sup>

### **RECOMMENDED WELDING PARAMETERS DCEP(+):**

Diameter	Position	Volts	Amps	WFS (in/min)
.035	V, OH	15	100	145
	F	24	200	395
.045	F, H	27	200	290
	F, H	32	300	525
	F, H	36	350	650
.052	F, H	28	250	295
	F, H	33	350	445
	F, H	39	450	650