

# MG 540 TIG

## THE PRODUCT TO USE ON CAST STEEL OR PROBLEM STEEL

DC REVERSE (ELECTRODE-)

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### **GENERAL CHARACTERISTICS:**

The MG 540 TIG is a premium wire that provides dense, strong, crack resistant deposits. MG 540 TIG is excellent for steels sensitive to cracking when welded with conventional mild steel fillers. Also available in a MIG wire.

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### **APPLICATIONS:**

For “tramp” and “problem” steels high in sulphur, phosphorus, or other elements added to improve the machinability of the steel. For fabrication of “H” and “I” beams, angle and channel iron, pipelines, and all other steel structures. For circular tube to plate welds, and other type joints subject to stress and strain.

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### **TECHNICAL DATA:**

Tensile Strength ..... up to 80,000 psi (552 N/mm<sup>2</sup>)  
Current ..... DC straight polarity (electrode-)  
Shielding Gas ..... 100% CO<sup>2</sup>

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### **PROCEDURE:**

Area to be welded should be cleaned thoroughly. Surface contamination must be removed also bevel or chamfer where required. Maintain close arc length. Vertical joints should be welded from bottom up, using rapid weave technique. Do not whip.