

# MG 540W

## ALL POSITION FLUX-CORED, GAS-SHIELDED ELECTRODE FOR MAINTENANCE AND REPAIR WELDING OF PROBLEM STEELS

### GENERAL CHARACTERISTICS:

MG 540W is designed with maintenance and repair welders in mind. This specially formulated flux-cored, gas-shielded, high strength wire has fast-freezing slag, making x-ray quality welds possible in all positions. Its ease of use makes it the maintenance and repair welder's choice for carbon and low alloy steels. Welds made with MG 540W have excellent tensile strength and superior impact resistance at normal and sub-zero temperatures.

### APPLICATIONS:

Use in all positions on problem steels such as those high in sulfur, phosphorus and tramp elements. Excellent for fabrication and repair of structural shapes, plates, piping and other structures. Use to repair broken machine parts, machining errors and build-up. Use for welding carbon and low alloy steels which will be subjected to high stress and strain.

### TECHNICAL DATA:

Tensile Strength ..... up to 93,000 psi (641 N/mm<sup>2</sup>)  
 Yield Strength ..... up to 83,000 psi (572 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% Argon, 25% CO<sup>2</sup> or 100% CO<sup>2</sup>

### RECOMMENDED WELDING PARAMETERS

Diameter	Position	Volts	Amps	WFS (in/min)
.035	F,H	22	100	195
	F,H	26	200	500
	F,H	29	250	740
	V,OH	22	100	195
	V,OH	25	175	400
	V,OH	27	225	625
.045	F,H	24	125	145
	F,H	27	250	400
	F,H	31	350	675
	V,OH	24	125	145
	V,OH	25	200	265
	V,OH	27	250	400
.052	F,H	23	150	120
	F,H	30	300	350
	F,H	33	400	550
	V,OH	23	150	120
	V,OH	25	200	190
	V,OH	26	250	270

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