

MG 610 TIG

UNIVERSAL TIG WIRE FOR HIGH TEMPERATURE AND CORROSION RESISTANT WELDS

DC STRAIGHT (ELECTRODE-)

GENERAL CHARACTERISTICS:

High alloy content of this wire produces deposits that are heat resistant up to 2190°F (1200°C). Good weldability in all positions and smooth beads make this wire very popular for both production and maintenance applications.

APPLICATIONS:

Welding 310, 314, 410 and 430 stainless steels. Cladding of steel subjected to elevated temperatures such as furnace parts, heat treating boxes, ladles, crucibles, heating plates, high temperature fan blades, tanks and grates.

TECHNICAL DATA:

Tensile Strength.....	up to 100,000 psi (689 N/mm ²)			
Yield Strength.....	up to 65,000 psi (448 N/mm ²)			
Elongation %	approx. 40			
Heat Resistance	2190°F (1200°C)			
Current	DC straight polarity (electrode-)			
Diameters (in)	3/32	1/8	5/32	
(mm)	2.4	3.2	4.0	

PROCEDURE:

Clean weld area. Bevel heavy sections to form a 75° vee. Preheat is not required. Stringer beads are recommended followed with peening to reduce stresses. Do not permit temperature of base metal to exceed 400°F (200°C). Avoid undercutting and deep penetration.