

MG 610

UNIVERSAL ELECTRODE FOR HIGH TEMPERATURE AND CORROSION RESISTANT WELDS

AC OR DC REVERSE (ELECTRODE+)

GENERAL CHARACTERISTICS:

High alloy content of this electrode produces deposits that are heat resistant up to 2190°F (1200°C). Good weldability in all positions, smooth beads, almost no spatter and easy slag removal makes this electrode 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	AC or DC reverse polarity (electrode+)			
Amperage	50-80	70-110	90-150	120-200
(in)	3/32"	1/8"	5/32"	3/16"
(mm)	2.4	3.2	4.0	5.0

PROCEDURE:

Clean weld area. Bevel heavy sections to form a 75° vee. Preheat is not required. Maintain a short arc. 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. Remove slag between passes.