

MG 650 TIG

**GENERAL PURPOSE,
LOW CARBON
STAINLESS STEEL TIG ROD**

General Characteristics

High quality general purpose stainless steel TIG wire with a low carbon content that has excellent welding characteristics. Very popular for both production and maintenance applications.

Applications

Welding 302, 304, 308 and 347 stainless steels. Designed for use on all normal and low carbon stainless steels except the molybdenum-bearing austenitic alloys. Ideal for welding materials that are subject to carbide precipitation. Normally used to fabricate and repair food, dairy and chemical equipment, household appliances, boilers, tanks, pipes and fittings. Also used as an elastic cushion prior to applying hard surfacing alloys.

Technical Data

Tensile Strength	up to 100,000 psi (689 N/mm ²)		
Yield Strength	up to 62,000 psi (427 N/mm ²)		
Elongation %	approx. 40		
Corrosion Resistance	good		
Current	DC straight polarity (electrode -)		
Diameters			
(in)	1/16	3/32	1/8
(mm)	1.6	2.4	3.2

Procedures

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.

