

MG 650

GENERAL PURPOSE LOW CARBON STAINLESS STEEL ELECTRODE

AC OR DC REVERSE (ELECTRODE+)

GENERAL CHARACTERISTICS:

High quality general purpose stainless steel electrode with a low carbon content that has excellent welding characteristics. The arc is very smooth and easy to control in all positions. It has outstanding arc-starting and restarting features with easy slag removal. Also available as a TIG wire.

APPLICATIONS:

Welding 302, 304, 308, and 347 stainless steel. 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	AC or DC reverse polarity (electrode+)		
Amperage	40-90	75-120	110-160
(in)	3/32"	1/8"	5/32"
(mm)	2.4	3.2	4.0

PROCEDURE:

Thoroughly clean weld area of all foreign material. A 60° bevel should be used when butt welding parts 3/16" (5.0mm) and heavier. Do not preheat. Tack parts to maintain alignment. Hold a medium short arc with electrode tilted 15° in the direction of travel. Prevent excessive heat build-up during welding operations. Remove slag between passes. Allow to cool slowly.