

MG 660 TIG

SPECIAL LOW CARBON TIG WIRE FOR MOLYBDENUM BEARING STAINLESS STEELS DC STRAIGHT POLARITY

GENERAL CHARACTERISTICS:

The low carbon content of MG 660 TIG prevents carbides from being formed at the grain boundaries and resultant intergranular corrosion.

APPLICATIONS:

Welding 302, 304, 308, and 316L stainless steels. Fabricating and repair of normal and low carbon molybdenum-bearing austenitic stainless steels. Commonly used to weld tanks, pipes, fittings, etc. in chemical plants and paper mills. Also used by the food, dairy, and distilling industries. Ideal as a protective overlay for steel that must resist corrosion.

TECHNICAL DATA:

Tensile Strength..... up to 100,000 psi (689 N/mm²)
Yield Strength up to 65,000 psi (448 N/mm²)
Elongation Approx. 40%
Corrosion Resistance very good
Current DC Straight Polarity
Gas 100% Argon

PROCEDURE:

Clean base metal of foreign substances, set parameters (appropriate for base metal thickness and position). Use direct current straight polarity and 100% Argon gas.