

MG 695

HIGH NICKEL ALLOY ELECTRODE FOR WELDING NICKEL CHROMIUM MOLYBDENUM ALLOYS DC REVERSE POLARITY (ELECTRODE+)

GENERAL CHARACTERISTICS:

Smooth welding electrode, with easy slag removal. Good weldability in all positions producing a porosity free weld deposit. The weld deposit has high strength at room and elevated temperatures. Excellent corrosion resistance, including resistance to pitting, and crevice corrosion. Also available in TIG.

APPLICATIONS:

For welding nickel-chromium-molybdenum alloys. Great for applications where the temperature ranges from cryogenic to 1000°F (540°C). Can be used for welding dissimilar alloys including Inconel®, Incoloy®, Stainless Steels, Low-Alloy Steels, and carbon steels. Also ideal for the surfacing and cladding of alloyed and mild steels.

TECHNICAL DATA:

Tensile Strength up to 118,000 psi (77 Kg/mm²)
Elongation 32%
Heat Resistance excellent
Corrosion Resistance excellent
Current DC reverse polarity (electrode+)

Amperage	40-65	65-90	90-125
(in)	3/32"	1/8"	5/32"
(mm)	2.5	3.25	4.0

TIG (in) 3/32" 1/8"

PROCEDURE:

Thoroughly clean weld area of all foreign material, including oil, lubricants and grease. A 60°-80° bevel should be used when butt welding base materials, (6mm), 1/4" and heavier. Maintain short to medium arc length. Stringer beads should be used, to minimize heat input to base metal. Interpass temperature should be kept below 300°F (150°C).

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