

MG 710 TIG

PREMIUM QUALITY MEDIUM HARDNESS ALLOY FOR MOST AIR HARDENING TOOL STEELS DC STRAIGHT POLARITY (DC-)

GENERAL CHARACTERISTICS:

Unique chemistry makes this TIG filler outstanding for the repair of most "air" hardening steels. Deposits are highly crack resistant, forgeable and temperable. Any number of passes can be made. Furthermore, repairs can be made in all positions.

APPLICATIONS:

Ideal for repair and build-up of shearing blades, planer plates, anvils, woodworking tools, percussion drills, earth borers, pressure rollers, clamping tools, worm conveyors, mixer arms, rollers, shovel and dredger teeth, crusher jaws and rings. Also for machine parts of steel, cast steel, and manganese steel which are subjected to grinding wear combined with strong impact.

TECHNICAL DATA:

Hardness as welded	55-60 RC			
Current	DC- straight polarity			
Sizes: (in)	1/16"	3/32"	1/8"	
(mm)	1.6	2.5	3.25	

PROCEDURE:

Use direct current straight polarity. One hundred percent argon gas is recommended. Adjust the amperage according to the base metal thickness and the amount of deposit required. In general it is not necessary to preheat, but if the base metal is of high carbon content, it should be preheated to approximately 750°F. If the base metal is known follow the tool steel welding procedures. Final tolerances may be obtained by grinding.