

MG 720

HARD SURFACING ELECTRODE FOR CORROSION RESISTANCE AT ELEVATED TEMPERATURES AC OR DC REVERSE (ELECTRODE +)

GENERAL CHARACTERISTICS:

Smooth running electrode composed of Cobalt that produces a flat weld with a high deposition rate. Deposits are highly resistant to moderate impact, abrasion, erosion, and corrosion at elevated temperatures. Surface can be polished and will maintain a low coefficient of friction.

APPLICATIONS:

Repair and surfacing of contact surfaces and guides in pumps, fittings, valve seats and cones, slide valve gates, discharge valves, stirrer shafts, punches, hot trimming dies, and stripper cranes.

TECHNICAL DATA:

Hardness	as welded up to 38-43 Rc		
	Hot Hardness approx. 42 Rc at 1020°F		
(550°C)			
Current	AC or DC Reverse Polarity (Electrode +)		
Amperage	80-100	100-140	140-180
(in)	3/32"	1/8"	5/32"
(mm)	2.5	3.25	4.0

PROCEDURE:

Remove all foreign material from weld area. Welding should be done in either the flat or horizontal position. Crack sensitive material must be preheated to 750-930°F (400-500°C) and maintained during the entire welding operation. Allow to cool slowly. The deposit can be machined with carbide-tipped tools.