

**MG 740W**

# EXTREMELY TOUGH BUILD-UP FLUX CORED WIRE AND UNDERBASE FOR HARDFACING

## **GENERAL CHARACTERISTICS:**

For medium hard and tough build-ups. Deposits can be machined with carbide tool bits. High compressive strength makes it a good underlay for hardfacing overlays, as well as a build-up material. Deposits can be forged as well as flame cut. No shielding gas needed.

## **APPLICATIONS:**

Build-up and padding of carbon and low alloy steels. Deposits can be built up to heavy thickness without danger of cracking. Can be used to rebuild tractor pads and rollers, wobblers, roll ends, rail and rail ends. Hardfacing of structural steel or cast steel machine components subjected to wear, such as slideways, truck wheels, wheel crowns, guides, couplings, brake drums and rope winches.

## **TECHNICAL DATA:**

Hardness Range .....						33-41 Rc
Current .....						DC Reverse Polarity
Diameters	(in)	0.45	1/16	5/64	3/32	7/64
	(mm)	1.2	1.6	2.0	2.5	2.8
Recommended Range	Volts	26-30	26-30	26-30	28-30	28-30
	Amps	120-175	200-275	225-275	275-350	275-350
Wire Stick Out		1½"-2"	1½"-2"	2"-2½"	2"-3"	2"-3"
Optimum Range	Volts	27	26	26	28	28
	Amps	140	240	250	300	300
Wire Stick Out		1¼"	1¼"	2¼"	2½"	2½"

## **PROCEDURE:**

Remove fatigued metal using MG 570. Deposit alloy with a stringer bead or weave technique. Electrode exhibits very low spatter loss. Deposits can be forged at medium heat. Not recommended for wearfacing manganese steel.