

MG-740

**EXTREMELY TOUGH BUILD UP
ELECTRODE AND UNDER BASE FOR
HARD FACING - RAPID
DEPOSITION
AC OR DC EITHER POLARITY**

GENERAL CHARACTERISTICS:

For medium hard and tough build-ups. Deposits are easy to machine. High compressive strength makes it a good underlay for hard facing overlays, as well as a build-up material. Deposits can be forged and flame cut. Very high build-up on straight polarity.

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. Hard facing of structural steel or cast steel machine components subjected to wear, such as slideways, truck wheels, wheel crowns, guides, couplings, brake drums, rope winches.

TECHNICAL DATA:

Hardness	BHN 312-391		
.....	Rc 33-41		
Current	AC or DC either polarity		
Amperage	90-110	120-140	160-170
(in)	1/8"	5/32"	3/16"
(mm)	3.25	4.0	5.0

PROCEDURE:

Remove fatigued metal using MG 570. Using AC or DC either polarity, deposit alloy with a stringer bead or weave technique. MG 740 deposits well in all positions with very low spatter loss. Deposits can be forged at medium heat. Use straight polarity for highest build-ups.