

MG 745W

**A HIGH ALLOY SELF-SHIELDING
FLUX CORED WIRE FOR JOINING
AND BUILD-UP OF AUSTENITIC
MANGANESE STEELS. EXCELLENT FOR
EXTREME IMPACT RESISTANCE.**

GENERAL CHARACTERISTICS:

This high chromium, high manganese alloy is ideal for the joining and build-up of 11-14% manganese steel and carbon steel. The high alloy deposits are machinable before work hardening.

APPLICATIONS:

For joining manganese steels to other alloy steels, especially designed for high impact applications such as rail frogs, switch points, roller crushers and hammers. Excellent for use as a base for harder overlays.

TECHNICAL DATA:

Hardness Range	as deposited	16-19 Rc					
	work hardened	45-50 Rc					
Typical Values	1 Pass	as deposited	19 Rc				
		work hardened	48 Rc				
	2 Pass	as deposited	21 Rc				
		work hardened	50 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	28-32	28-32	
	Amps	100-190	175-275	225-300	275-375	275-375	
Wire Stick Out		1"-1½"	1½"-2"	2"-2½"	2"-3"	2"-3"	
Optimum Range	Volts	28	26	28	28	28	
	Amps	140	200	250	325	325	
Wire Stick Out		1¼"	1¾"	2¼"	2½"	2½"	

PROCEDURE:

Remove any unsound or fatigued material with MG 570. Build-up surface area using stringer or weave beads. Use as low a voltage as possible and keep the travel angle as straight into the base material as possible. Increased lead angle may cause porosity. Avoid overheating manganese steel.