

MG-745

**A HIGH ALLOY ELECTRODE FOR
JOINING AND BUILD-UP OF
AUSTENITIC MANGANESE STEELS FOR
EXTREME IMPACT RESISTANCE
AC OR DC REVERSE POLARITY (ELECTRODE+)**

GENERAL CHARACTERISTICS:

This high chromium, high manganese alloy is for joining and rebuilding manganese and carbon steel parts. The high alloy deposits are very tough and will take extreme impact and abrasion conditions. Has excellent weldability with very low spatter. Operates easily in all positions.

APPLICATIONS:

For rebuilding and joining austenitic manganese steels and manganese steels to other steel combinations. Especially designed for high impact applications such as rail frogs and switch points, roller crushers, hammers, shovel tracks. MG 745 is also excellent for use as a base for harder overlays.

TECHNICAL DATA:

Hardness	as deposited: Rc 16-19			
.....	work hardens to: Rc 48			
Current	AC or DC reverse polarity (electrode+)			
Amperage	110-135	125-190	150-250	225-325
(in)	1/8	5/32	3/16	1/4
(mm)	3.2	4.0	5.0	6.0

PROCEDURE:

Remove any hardened or fatigued material from the surface with MG 570. Deposits may be placed with either the stringer bead or weaving technique. This electrode deposits easily in all positions with excellent build-up quality. Avoid over-heating on manganese steel base metals. Deposits work harden rapidly.