

MG 746W

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

GENERAL CHARACTERISTICS:

The MG 746W produces strong, dense deposits with minimum spatter. The deposit is machinable before work hardening and can be flame cut.

APPLICATIONS:

The MG 746W is used to join or build up 11-14% manganese steel or steels requiring good impact or compressing strength. It is recommended for rail frogs, switch points, roller crushers, hammers, shovel tracks, bucket teeth, and as underlay for harder deposits.

TECHNICAL DATA:

Hardness Range	as welded	15-18 Rc			
	work hardened	45-55 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	120-175	175-275	225-275	250-350	
250-350						
Wire Stick Out		1"-1½"	1½"-2"	2"-2½"	2"-3"	2"-3"
Optimum Range	Volts	27	28	28	28	28
	Amps	140	240	250	330	330

PROCEDURE:

Remove any unsound or fatigued material with MG 570. Build-up surface area using stringer or weave beads. Use as high a current that gives puddle control, consistent with thickness of material and position. Use as low a voltage as possible and keep the travel angle as straight into the base material as possible. Increased angle may cause porosity. Avoid overheating on manganese steel base metals.