

MG 765W

SUPERIOR HIGH ALLOY FLUX CORED WIRE WITH EXCELLENT ABRASION RESISTANCE ALONG WITH LIGHT IMPACT.

GENERAL CHARACTERISTICS:

MG 765W is designed for use on carbon and low alloy steels, manganese steels and cast iron. Deposits take on a high polish which contributed to high frictional and abrasion wear qualities, especially small particle abrasion. Excellent on applications that need abrasion resistance along with light impact. Provides optimum resistance to this combination. No shielding gas required.

APPLICATIONS:

MG 765W is recommended for severe abrasion applications, along with moderate impact. This alloy also has good hot hardness up to approximately 1,000°F. Especially designed for crusher applications. Used heavily in construction, mining, brick and clay industries on parts such as crusher rolls, jaw crushers, bucket teeth edges, hammers, mill hammers and conveyor screws.

TECHNICAL DATA:

Hardness Range					57-61 Rc
Current					DC (+) Reverse Polarity
Diameters	(in)	0.035	0.045	1/16	7/64
	(mm)	0.9	1.2	1.6	2.8
Recommended Range	Volts	17-22	26-30	26-30	30-35
	Amps	90-150	100-190	175-275	275-425
Wire Stick Out		1/2"-3/4"	1"-2"	1 1/2"-2"	2"-3"
Optimum Range	Volts	19	28	28	32
	Amps	130	140	225	350
Wire Stick Out		3/4"	1 1/4"	1 3/4"	2 1/2"

PROCEDURE:

Remove any fatigued or unsound metal with MG 570. According to the thickness of deposit and type of base metal, a padding of MG 740, MG 750 or MG 600 might be considered, and a cushion of MG 200 is recommended on cast iron. Prevent excessive heat build-up. Allow parts to cool slowly.