

MG-769

**WEARFACING ELECTRODE FOR
MODERATE ABRASION & IMPACT
AC OR DC REVERSE POLARITY (ELECTRODE+)**

GENERAL CHARACTERISTICS:

General purpose surfacing alloy for surfaces subjected to abrasive wear and impact. Special alloying and fluxing agents produce the ultimate porous-free high density crack resistant weld deposit.

APPLICATIONS:

Build-up and surfacing of new and worn machine parts of steel, and cast steel. An excellent product to use on earth moving and rock crushing machinery parts. Excellent for out-of-position application.

TECHNICAL DATA:

Hardness as welded up to 54-58 RC
Current AC or DC reverse polarity
(electrode+)

Amperage	80-100	100-140	140-180	180-230
(in)	3/32"	1/8"	5/32"	3/16"
(mm)	2.5	3.25	4.0	5.0

PROCEDURE:

Remove any unsound or fatigued material with the MG 570. Build surface using either stringer or weave beads. Select the current and amperage that gives puddle control, consistent with thickness of material and position.