MG 770W

HARD SURFACING SELF-SHIELDED FLUX CORED WIRE FOR SEVERE ABRASION

GENERAL CHARACTERISTICS:

MG 770W produces smooth beads. The arc is easily controlled and prevents excessive dilution with the base metal. The high chromium content allows the weld deposit to maintain abrasion resistance even at elevated temperatures.

APPLICATIONS:

Parts subjected to severe abrasion as well as light impact such as equipment for processing soil, rock, coal, cement:; grinding plates, dredger teeth, conveyor screws, coal augers, agitators, earth augers, and scrapers. Also for surfaces that must resist abrasion combined with scaling such as open-hearth tools, grates, conveyor chains in annealing furnaces.

TECHNICAL DATA:

Hardness Range						56-60 Rc
Typical Values	1 Pass					56 Rc
	2 Pass					58 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	28-32	30-35	30-35
	Amps	120-160	210-275	250-325	275-425	275-425
Wire Stick Out		1”-2”	1½”-2”	2”-2½”	2”-3”	2”-3”
Optimum Range	Volts	26	28	30	32	32
	Amps	150	230	275	350	350
Wire Stick Out		1½”	1¾”	2”	2½”	2½”

PROCEDURE:

Remove foreign material and unsound metal from surface to be welded with MG 570. For best results and long service life an elastic cushion layer should be applied to the part before surfacing with this electrode. Use MG 740W for a cushion layer on carbon steels and maganese steels; on cast iron use MG 200W. Deposits must be kept thin, never more than two layers thick. If possible, allow part to cool slowly.

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