

MG-799

A SUPER ABRASION AND FRICTIONAL WEAR RESISTING ALLOY WITH EXCELLENT CORROSION AND HEAT RESISTANCE FLAME ADJUSTMENT - NEUTRAL

GENERAL CHARACTERISTICS:

Easily applied as a gas brazing type alloy. The dense deposit gives it a very low coefficient of friction with resistance to corrosion. The wide plastic range enables the deposit to be formed or shaped. A smooth finish helps reduce finishing costs. This very versatile alloy can also be used as an arc rod on DC reverse polarity and with tig on DC straight polarity.

APPLICATIONS:

Excellent for metal to metal wear applications. Used where hardness is needed at higher temperatures such as valve faces, core drills, scrapers and wire straightening shoes; for cams, bushings and augers. Extensively used on cane knives and chemical pump sleeves.

TECHNICAL DATA:

Hardness	up to 56-62 Rc	
Flame adjustment	Neutral	
Bonding temperature	approx. 1800°F	
Current		
	Arc	DC reverse polarity (electrode+)
	Tig	DC Straight Polarity (electrode -)
Amperage	1/8	3/16
Arc	100-130	140-175
Tig	80-110	110-150

PROCEDURE:

The area to be overlaid should be clean. Remove any surface oxidation by grinding or grit blasting. Use a neutral flame to preheat the start of the work area up to a sweat or brazing heat (just before red starts to show), apply a small amount of MG 799 and wet or tin the surface, then add more alloy to build-up using a bead forming technique. MG 799 is self-fluxing on most applications. If you require a flux, use MG 130 PF. Try to cool as slow as possible. Grind to finish.