

MG "SUPER" 600

THE ULTIMATE ELECTRODE FOR WELDING ALL TYPES OF STEELS, WITHOUT ANY DANGER OF CRACKING OR BREAKAGE

GENERAL CHARACTERISTICS:

Because maintenance shops often have old or inexpensive welding equipment, "Super" 600 has been formulated to provide the best possible arc stability, even under adverse conditions. It is amazingly stable on low, open circuit voltages, AC buzz boxes. The weld metal transfer is especially smooth and there is almost no spatter. Arc restrike is instantaneous. We have even managed to make the slag virtually self-releasing. It is without doubt the best possible product to use on unknown steels and dissimilar metal combinations.

APPLICATIONS:

Due to its exceptional strength and crack resistance, it is ideal for repairing tools, dies, spring steel, and any dissimilar metal combinations, with the exception of the aluminums and copper alloys. Because the weld metal is so tough, it is also recommended for repairing worn parts, and also as an underlayment for hard facing. Because of its low amperage requirements and exceptional ease of its use, it should be the first choice for both home hobbyists and maintenance welders for general applications.

TECHNICAL DATA:

Tensile Strength	as welded	up to 128,000 psi (882 N/mm ²)				
	work hardened	up to 186,000 psi (1282 N/mm ²)				
Yield Strength	up to 90,000 psi (620 N/mm ²)					
Elongation %	approx. 32					
Hardness (HB)	approx. 320					
Current	AC or DC reverse polarity (electrode+)					
Amperage	25-35	35-70	60-110	75-140	130-200	
(in)	1/16"	3/32"	1/8"	5/32"	3/16"	
(mm)	1.6	2.4	3.2	4.0	5.0	

PROCEDURE:

The area in which the weld is to be made should be free of rust, grease, paint, and other materials which cause weld contamination. A 90° vee should be used when joining heavy sections. Preheat is necessary only for high carbon steels, which should be preheated to 350°F (177°C). The interpass temperature should be kept below 500°F (260°C). Alignment should be maintained by the use of fixtures, tack welds, or other types of mechanical support. Maintain a short arc length and use stringer beads. Avoid weaving whenever possible.