

MG 200 MIG

*High nickel MIG wire for welding cast iron,
maximum machinability*



GENERAL CHARACTERISTICS:

Specially formulated high nickel wire for MIG welding cast iron requiring smooth, spatter free machinable deposits. MG 200 MIG provides dense deposits with high ductility on cast irons that are not severely contaminated.

APPLICATIONS:

Use MG 200 MIG where minimum heat input and dilution are required, repairing or building up engine blocks, gear housings, and machine bases. Also excellent for filling holes or building up missing sections, underlayment for hardfacing, and may be used for joining cast iron to steel, stainless steels, and other dissimilar materials.

TECHNICAL DATA:

Typical Tensile Strength	up to 50,000 psi (345 N/mm ²)
Hardness	Approx. 160 HB
Polarity	DC reverse polarity (electrode +)
Shielding Gas	100% Argon or 75/25 AR/CO ²

Diameter	Voltage	Amperage
.035	16-20	25-160
.045	20-22	140-190

PROCEDURE:

Remove foreign materials. Preheat to 400°F using short arc procedures. Apply weld with stringer beads with slight side to side motion. Fill all craters and peen welds to relieve stress.