MG 210

Maximum strength alloy for cast iron

GENERAL CHARACTERISTICS:

Welds produced by this electrode are high strength, crack resistant, porosity free yet, machinable when applied to a wide variety of cast irons. The special core wire has a high current carrying capacity and the coating is designed to convert the impurities of the base metal into slag instead of being entrapped in the deposit. The soft arc prevents deep penetration, therefore the weld is easily machined.

APPLICATIONS:

For fabrication and difficult repair of all gray and alloyed cast irons. Recommended for welding cylinder heads, machine bases, gear housings, cams, levers, filling holes, repairing teeth of cast gears and building up or replacing missing sections. Commonly used to weld ductile iron, “Ni-Resist” and “Meehanite” to themselves or to steel. Also suitable for joining nickel alloys to gray cast iron, malleable cast iron and cast steel.

TECHNICAL DATA:

Typical Tensile Strength	Up to 80,000 psi (552 N/mm^2)
Hardness	Approx. 200 HB
Current	AC or DC straight (electrode -)

Diameter	Amperage
3/32” (2.4mm)	35-80
1/8” (3.2mm)	65-120
5/32” (4.0mm)	75-140

PROCEDURE:

Clean weld area if possible. Remove surface skin and all sharp edges. Bevel joint to form a “U” groove. A bead hole must be welded at right angles to each end of all cracks to prevent spreading during welding. Use low amperage and maintain a short arc. Short stringer beads or narrow weave beads should be used to prevent excessive heat build-up. When breaking the arc always fill the crater and drag rod back over the weld deposit. Peening while still hot will help reduce stresses. When re-striking the arc start on previously deposited weld metal, not on the base material. Allow part to cool slowly.