

# MG 200 TIG

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



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## **GENERAL CHARACTERISTICS:**

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

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## **APPLICATIONS:**

Use MG 200 TIG 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.

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## **TECHNICAL DATA:**

Typical Tensile Strength	50,000 psi (345 N/mm <sup>2</sup> )
Typical Hardness	HB 160
Polarity	DC straight polarity (electrode -)
Shielding Gas	100% Argon

Diameter	Amperage	Tungsten Dia.	Work Thickness	Shielding Gas	Flow Rate
1/16" (1.6mm)	55-90	1/16"	1/16"	100% Argon	20-25 scfh
3/32" (2.4mm)	80-140	3/32"	3/16"	100% Argon	25-30 scfh
1/8" (3.2mm)	100-200	3/32"	3/8"	100% Argon	30-40 scfh

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## **PROCEDURE:**

Remove foreign materials. Preheat to 400°F. Slow cool following welding.