

MG 262



Premium Cast Iron Electrode for Multi-Layer Welds Where High Strength is Essential

GENERAL CHARACTERISTICS:

Outstanding elongation in this graphite coated electrode makes it excellent for welding nodular and gray cast iron when ductile deposits are required. Special bi-metal core wire prevents overheating.

APPLICATIONS:

Use on all weldable grades of cast iron when multi-layer deposits requiring high strength, good ductility and machinability are a must. Excellent for complex castings.

TECHNICAL DATA:

Specification	AWS A5.15 Class ENiFeMn-CI
Typical Tensile Strength	Up to 80,000 psi (56 kg/mm ²)
Typical Hardness	200 HB
Typical Yield Strength	63,000 psi (44 kg/mm ²)
Elongation %	24
Polarity	AC or DC reverse (electrode +)

Diameter	Amperage
3/32" (2.4mm)	70-100
1/8" (3.2mm)	90-150
5/32" (4.0mm)	100-180

PROCEDURE:

Clean weld area as much as possible. On heavy sections, remove worn, cracked metal, and bevel joint using MG 570 or a grinding wheel. If the weld area is contaminated with oil or grease it may be removed by using a strong oxidizing oxy-acetylene flame to burn it off. On very heavy sections, preheat to approximately 400°F.

