

MG 530

**Ultra high strength electrode
for low and medium carbon steels**



GENERAL CHARACTERISTICS:

All position, low hydrogen iron powder type electrode with a fast and efficient metal transfer. Deposits have outstanding elongation and ductility and provide crack-free welds under highly stressed conditions. The slag is easily removed from the smooth welds which are easily machined.

APPLICATIONS:

MG 530 is designed to weld low alloy high strength (HSLA) steels such as T-1, Hy-80, Hy-90, Hy-100, SSS 100 and Jalloxy 90 and 100. Commonly used to fabricate tanks, containers, covers and high strength pipe. Also recommended for welding low alloy steels containing nickel, manganese, molybdenum and chromium such as I-beams, angle iron, scaffolding and superstructures. Weld can be used "as welded" or "stress relieved".

TECHNICAL DATA:

Tensile Strength	Up to 113,000 psi (779 N/mm ²)
Yield Strength	Up to 104,000 psi (717 N/mm ²)
Elongation	Approx. 23%
Current	AC or DC reverse polarity (electrode +)

Diameter	Amperage
3/32" (2.4mm)	70-120
1/8" (3.2mm)	100-150
5/32" (4.0mm)	120-210
3/16" (5.0mm)	200-275

PROCEDURE:

No preheat is necessary when welding low carbon steels. When joining heavy sections to thin sections and when low alloy or higher carbon steels are welded, preheat to 400°F and maintain a 600°F maximum interpass temperature. Maintain a short arc with either stringer or weave beads. Allow deposit to cool normally before chipping off slag. To stress relieve, heat to 1025°F (550°C) and maintain for 1 hour.

