

# MG 600 MIG

*The strongest, problem solving, universal wire for all steels*



## **GENERAL CHARACTERISTICS:**

MG 600 MIG is a premium wire that provides dense, porosity and spatter free deposits that are strong and crack resistant. This wire is compatible to all grades and alloys of steel. Also available as a TIG wire.

## **APPLICATIONS:**

Welding low, medium, and high alloy steels requiring the highest strength and quality. Ideal for repair of tools, dies, springs, carbon steels, stainless steels, pressure vessels, aircraft steels, vanadium-moly spring steels and as an underlayment or pad prior to applying hard facing alloys. Also used for rebuilding shafts and blades used in the chemical, construction and mining industries.

## **TECHNICAL DATA:**

Tensile Strength	As Welded: up to 120,000 psi (827 N/mm <sup>2</sup> )
	Work Hardened: up to 180,000 psi (1241 N/mm <sup>2</sup> )
Yield Strength	Up to 90,000 psi (621 N/mm <sup>2</sup> )
Elongation	Approx. 35%
Hardness	Approx. 300 HB
Current	AC or DC reverse polarity (electrode +)
Gas Flow	20-35 CFH
Shielding Gas	Short arc 75/25% or 90% He 7.5% Ar 2.5% Co <sup>2</sup>
	Spray arc 99% Ar 1% O <sup>2</sup> or 98% Ar 2% O <sup>2</sup>

Diameter	Amperage	Voltage	Wire Feed ipm
.035" (.9mm)	60-160	15-24	90-290
.045" (1.2mm)	190-300	22-30	200-370

## **PROCEDURE:**

Clean material of foreign substances, set parameters to range given (appropriate for base metal thickness and position). Preheat high carbon steels to 400°F. Use stringer beads to minimize overheating and stress.

