

MG 665

**VERTICAL
DOWN**

**UNIQUE VERTICAL DOWN
STAINLESS STEEL
MAINTENANCE AND REPAIR
ELECTRODE
AC OR DC REVERSE POLARITY**

GENERAL CHARACTERISTICS:

This stainless steel electrode was specifically designed for vertical down or vertical up welding of austenitic stainless steel. The weld deposits are fast, smooth, and corrosion resistant. Especially quick-freeze characteristics of the weld pool make this an excellent product for poorly fitted joints in all positions. Low amperage requirement controls distortion often associated with welding thin sheet metal, and spatter is kept to a minimum.

APPLICATIONS:

Vertical down or vertical up welding of pipe lines, sheet metal, and other applications where excellent weldability is needed. Also used for fabrications of thin, medium, heavy and dissimilar gauge mild steel. An excellent choice when welding 302, 304, 308 and 316L stainless steel. Ideal as a protective overlay for steel that must resist corrosion.

TECHNICAL DATA:

Tensile Strength up to 80,000 psi (55 Kg/mm²)
Yield Strength up to 56,000 psi (39 Kg/mm²)
Elongation approx. 42%
Current AC or DC reverse polarity

Amperage	60-80	90-110
(in)	3/32"	1/8"
(mm)	2.4	3.2

Welding Positions Flat, Horizontal, Vertical Up, Vertical Down, Overhead

PROCEDURE:

Thoroughly clean weld area of all foreign material. A 60° bevel should be used when butt welding parts 3/16" (5.0 mm) and heavier. Tack parts to maintain alignment. Hold a medium short arc with electrode tilted 25° in the direction of travel. Prevent excessive heat build-up during welding operations. Remove slag between passes. Allow to cool slowly.