MG 670

High deposition build-up electrode for stainless steel

GENERAL CHARACTERISTICS:

MG 670 is an all-position electrode which quickly deposits smooth, dense, corrosion resistant welds. Minimal spatter and self-releasing slag makes clean-up fast and easy for streamlined welding procedures. MG 670 is ideal for applications involving molybdenum bearing and austenitic stainless steels or combinations of stainless, carbon and low-alloy steels.

APPLICATIONS:

Welding 302, 304, 308 and 316L stainless steels with high deposition rates. Fabricating and repair of normal and low carbon molybdenum-bearing austenitic stainless steels. Ideal for joining low carbon austenitic stainless steels with mild steels. Commonly used to weld tanks, pipes, fittings, etc. in chemical plants and paper mills. Also used by food, dairy, and distillery industries. Ideal as a protective overlay for steel that must resist corrosion.

TECHNICAL DATA:

Typical Tensile Strength	Up to 105,000 psi (600-750 N/mm^2)
Typical Yield Strength	Up to 62,000 psi (420 N/mm^2)
Elongation	Approx. 35%
Corrosion Resistance	Very good
Current	AC or DC reverse polarity (electrode +)

Diameter	Amperage
5/64” (2.0mm)	60-80
3/32” (2.4mm)	90-110
1/8” (3.2mm)	120-160
5/32” (4.0mm)	160-190
3/16” (4.8mm)	150-210

PROCEDURE:

Clean weld area of residue, scale and oxides. Preheating is generally not needed when welding stainless steels. For heavy section parts and hardenable tool steels check the preheat/inter-pass temperature guidelines with an expert. Maintain a short to medium arc while depositing stringer or weave beads. Do not weave more than 3x electrode diameter. Parts which have been preheated should be wrapped or covered with heat – retardant material to help with slow cooling.