

MG 700



Premium quality, high hardness alloy for most tool steels

GENERAL CHARACTERISTICS:

This electrode is specially formulated for use on high speed steels. Tungsten, molybdenum and vanadium have been alloyed with other elements to produce a deposit that will maintain a sharp edge on high speed tools and retain its hardness and resistance to wear at the high operating temperatures.

APPLICATIONS:

Build-up and hardfacing of molding plates, mandrels, hot shears, reamers, turning and planing tools, drawing mandrels and dies, circle cutting tools, trimming plates, stencils, punches, cams, lathe tools, mill cutters and sliding surfaces.

TECHNICAL DATA:

Hardness	As Welded: up to 58-62 HRC
	Heat Treated: 63-65 HRC
Hot Hardness	Approx. 56 HRC at 110°F (60°C)
Current	AC or DC either polarity

Diameter	Amperage
3/32" (2.4mm)	45-90
1/8" (3.2mm)	80-120
5/32" (4.0mm)	120-160

PROCEDURE:

Remove all foreign material from weld area. When the base metal is tool steel, preheat part to 800-1100°F (425-600°C); maintain this temperature during the entire welding operation. No preheat is required when making deposits on low carbon steel but a minimum of 3 layers is necessary to overcome dilution. Do not quench after welding, remove slag and reheat to 1000°F (540°C), allow to cool slowly. The deposit can then be ground to final dimension.

Also available in TIG.

