

MG 7065 THF

**High deposition, oxidization resistant,
tubular electrode for severe abrasion and
medium impact**



GENERAL CHARACTERISTICS:

MG 7065THF is unique tubular hard-surfacing electrode ideal for applications involving heavy fine particle abrasive wear. A moisture resistant coating protect the steel tube and its contents from environmental pick-up, providing fast deposition of quality material with very little energy, material, or time wasted.

APPLICATIONS:

Use for severe abrasion and medium impact This alloy has good hot hardness up to 1000°F. Designed for crusher rolls, jaw crushers, crusher mantle and liners, hammer mill hammers, bucket teeth and edges.

TECHNICAL DATA:

Hardness	As Welded: up to 56-62 HRC
Deposit Efficiency	Up to 96%
Polarity	AC or DC (+/-)

Diameter	Amperage
1/4" (6.4mm)	85-135
3/8" (9.5mm)	130-190
1/2" (12.0mm)	200-430

PROCEDURE:

Remove contaminated, fatigue or unsound metal. Clean remaining residue and oxides as best possible. When welding on low-carbon or manganese steels a preheat is generally not necessary but may be used to drive off surface moisture when ambient temperature are below 50°F. Higher alloys should be preheated and slow cooled in accordance with their hardenability. If unsure of temperature or procedure, consult and expert. When a thick build-up is required, a cushion layer of MG 740 or 750 on steels and MG 200 on cast irons is advisable. Apply 7065 with a short to medium arc and a drag technique for a maximum of 2 layers deep.

