

MG 7070 THF

**Severe fine particle abrasion resistant,
tubular alloy, with complex carbides in an
austenitic matrix**



GENERAL CHARACTERISTICS:

MG 7070THF is unique tubular hard-surfacing electrode ideal for applications involving severe fine particle wear at moderate to high temperatures. 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. Deposits will polish to a shine in service.

APPLICATIONS:

Use for parts subjected to severe abrasion such as brick extrusion augers, muller plows, pan scraper blades, bulldozer end bits, conveyor chains in annealing furnaces and other equipment used in rock, coal, cement and ceramic industry where small particle abrasion is a problem.

TECHNICAL DATA:

Hardness	As Welded: 55-60 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 7070 with a short to medium arc and a drag technique for a maximum of 2 layers deep.

