

MG 7090 THF

Ultimate tubular electrode for abrasion resistance in severe environments



GENERAL CHARACTERISTICS:

MG 7090 THF weld metal is composed of complex carbides in an exceptionally strong matrix resulting in a coating highly resistant to fine particle abrasion and erosion at temperatures up to 1500°F.

APPLICATIONS:

Conveyors for hot coke, slag and cement. Kiln grates, crushers and other equipment subjected to abrasion and erosion at elevated temperatures. Very good for extreme abrasion, such as crusher cones and mantles in taconite-crushing operations. Excellent for feed chutes handling hot abrasive materials.

TECHNICAL DATA:

Matrix Hardness	62-64 HRC
Carbide Hardness	Vickers 1950
Polarity	AC or DC (+/-)

Diameter	Amperage
1/4" (6.4mm)	85-135
3/8" (9.5mm)	130-190
1/2" (12.0mm)	180-390

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 an 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.

