

MG 720

Hard surfacing electrode for corrosion resistance at elevated temperatures



GENERAL CHARACTERISTICS:

Smooth running electrode composed of Cobalt that produces a flat weld with a high deposition rate. Deposits are highly resistant to moderate impact, abrasion, erosion, and corrosion at elevated temperatures. Surface can be polished and will maintain a low coefficient of friction.

APPLICATIONS:

Repair and surfacing of contact surfaces and guides in pumps, fittings, valve seats and cones, slide valve gates, discharge valves, stirrer shafts, punches, hot trimming dies, and stripper cranes.

TECHNICAL DATA:

Hardness	As Welded: up to 38-43 HRC
	Hot Hardness: approx. 42 HRC at 1020°F (550°C)
Polarity	AC or DC reverse (electrode +)

Diameter	Amperage
3/32" (2.4mm)	80-100
1/8" (3.2mm)	100-140
5/32" (4.0mm)	140-180

PROCEDURE:

Clean weld area of residue, scale and oxides. For heavy section parts and hardenable tool steels a minimum preheat of 750-960°F (400-500°C) is recommended. If uncertain, consult an expert for preheat and inter-pass temperature guideline. Maintain a short to medium arc while depositing stringer or weave beads. Do not weave more than 3x electrode diameter. Parts should be wrapped or covered with heat-retardant material and slow cooled.

