

# MG 740W

**Flux-cored wire for tough build-up and underlayer deposits.**



## GENERAL CHARACTERISTICS:

For deposits of intermediate hardness and toughness on plain carbon and most construction steels. MG 740W deposits quality welds in all positions with excellent efficiency and recovery rates. Its high compressive strength makes MG 740W a good foundation for hard- and wear-facing applications as well as a rebuild alloy. Deposits can be machined, forged and flame cut. Shielding gas is optional.

## APPLICATIONS:

Build-up and padding of carbon and low alloy steels. Deposits can be built up to a heavy thickness without danger of cracking. Can be used to rebuild tractor pads and rollers, wobblers, roll ends, rail and rail ends. Hardfacing of structural steel or cast steel machine components subjected to wear, such as slideways, truck wheels, wheel crowns, guides, couplings, brake drums and rope winches.

## TECHNICAL DATA:

Hardness Range	33-41 HRC
Polarity	DC reverse (electrode +)

Recommended Range			
Diameter	Amperage	Volts	Wire Stick Out
0.045" (1.2mm)	120-175	26-30	1 1/2"-2"
1/16" (1.6mm)	200-275	26-30	1 1/2"-2"
7/64" (2.8mm)	275-350	28-30	2"-3"
Optimum Range			
Diameter	Amperage	Volts	Wire Stick Out
0.045" (1.2mm)	140	26	1 3/4"
1/16" (1.6mm)	240	26	1 3/4"
7/64" (2.8mm)	300	28	2 1/2"

## PROCEDURE:

Remove fatigued metal with MG 560 or MG 570 and clean remaining oxides and debris. Deposit stringer or weave beads as needed. Deposits can be forged at medium heat.

