MG 745W

A high alloy self-shielding flux cored wire for joining and build-up of austenitic manganese steels. Excellent for extreme impact resistance

MESSER MG Welding Products

GENERAL CHARACTERISTICS:

This high chromium, high manganese alloy is ideal for the joining and build-up of 11-14% maganese steel and carbon steel. The high alloy deposits are machinable before work hardening.

APPLICATIONS:

For joining manganese steels to other alloy steels, especially designed for high impact applications such as rail frogs, switch points, roller crushers and hammers. Excellent for use as a base for harder overlays.

TECHNICAL DATA:

Typical Hardness Range	As Deposited: 16-19 HRC
	Work Hardened: 45-50 HRC
Typical Values 1 pass	As Deposited: 19 HRC
	Work Hardened: 48 HRC
Typical Values 2 pass	As Deposited: 21 HRC
	Work Hardened: 50 HRC
Polarity	DC reverse (electrode +)

Recommended Range			
Diameter	Amperage	Volts	Wire Stick Out
0.045” (1.2mm)	100-190	26-30	1”-1 1/2”
1/16” (1.6mm)	175-275	26-30	1 1/2”-2
7/64” (2.8mm)	275-375	28-32	2”-3”

PROCEDURE:

Remove any unsound or fatigued material using MG 570. Build-up surface area using stringer or weave beads. Use as low a voltage as possible and keep the travel angle as straight into the base material as possible. Increased lead angle may cause porosity. Avoid overheating manganese steel.