

MG 745

All position, work hardening, joining and build-up electrode for manganese steels



GENERAL CHARACTERISTICS:

This high chromium, high manganese alloy is for joining and rebuilding manganese and carbon steel parts. The high alloy deposits are very tough and will take extreme impact and abrasion conditions. Has excellent weldability with very low spatter. Operates easily in all positions.

APPLICATIONS:

For rebuilding and joining austenitic manganese steels and manganese steels to other steel combinations. Especially designed for high impact applications such as rail frogs and switch points, roller crushers, hammers, shovel tracks. MG 745 is also excellent for use as a base for harder overlays.

TECHNICAL DATA:

Hardness	As Welded: up to 16-19 HRC
	Work Hardens: up to 48 HRC
Polarity	AC or DC reverse (electrode +)

Diameter	Amperage
1/8" (3.2mm)	110-135
5/32" (4.0mm)	125-190
3/16" (5.0mm)	150-250
1/4" (6.4mm)	200-350

PROCEDURE:

Remove any hardened or fatigued material from the surface with MG 570. Deposits may be placed with either the string bead or weaving technique. Avoid overheating on manganese steel base metals.

