

MG 746W

A high alloy flux cored wire for joining and build-up of austenitic manganese steels



GENERAL CHARACTERISTICS:

Excellent for extreme impact resistance. The MG 746W produces strong, dense deposits with minimum spatter. The deposit is machinable before work hardening and can be flame cut.

APPLICATIONS:

The MG 746W is used to join or build-up 11-14% manganese steel or steels requiring good impact or compressing strength. It is recommended for rail frogs, switch points, roller crushers, hammers, shovel tracks, bucket teeth, and as underlay for harder deposits.

TECHNICAL DATA:

Hardness Range	As Welded: 15-18 HRC
	Work Hardened: 45-50 HRC
Polarity	DC reverse (electrode +)

Recommended Range			
Diameter	Amperage	Volts	Wire Stick Out
0.045" (1.2mm)	120-150	24-26	1"-2"
1/16" (1.6mm)	180-250	26-28	1 1/2"-2 1/2"
7/64" (2.8mm)	250-350	28-30	2"-3"
Optimum Range			
Diameter	Amperage	Volts	
0.045" (1.2mm)	140	25	
1/16" (1.6mm)	240	27	
7/64" (2.8mm)	330	29	

PROCEDURE:

Remove any unsound or fatigued material with MG 570. Build-up surface area using stringer or weave beads. Use as high a current that gives puddle control, consistent with thickness of material and position. Use as low a voltage as possible and keep the travel angle as straight into the base material as possible. Increased angle may cause porosity. Avoid overheating on manganese steel base metals, do not exceed 550°F.

