

MG 750

Joining and build-up of steels for impact resistance



GENERAL CHARACTERISTICS:

MG 750 is smooth-running , high deposition electrode which provides quality long-lasting welds. Deposits are heat-resistant, do not cross-check or rust and work-harden in service to provide the best impact resistance in any build-up application, including low-alloy, manganese and stainless steels.

APPLICATIONS:

Under-layers, joining and build-up of railroad tracks, frogs and switches, mill hammers, rolls and mantles. Mining and construction equipment fabrications and refurbishing.

TECHNICAL DATA:

Typical Tensile Strength	86,000 psi (593 N/mm ²)
Typical Yield Strength	62,000 psi (427 N/mm ²)
Elongation	Approx. 40%
Hardness	As Welded: up to 10 HRC
	Work Hardness: up to 45 HRC
Polarity	AC or DC reverse (electrode +)

Diameter	Amperage
1/8" (3.2mm)	90-130
5/32" (4.0mm)	120-160
3/16" (5.0mm)	140-190

PROCEDURE:

Remove contaminated, fatigue or unsound metal. Clean remaining residue and oxides as best possible. When welding on low-carbon or manganese steels a preheat is generally not necessary but may be used to drive off surface moisture when ambient temperature are below 50°F. During welding Manganese steels should not be allowed to exceed 600°F. Higher alloys should be preheated and slow cooled in accordance with their hardenability. If unsure of temperature or procedure, consult an expert. Apply with short to medium arc in stringer or weave beads. Clean well between weld beads.

Also available in a flux cored wire.

