MG 755

Medium hardness and impact resistance on most iron alloys

MESSER MG Welding Products

GENERAL CHARACTERISTICS:

For carbon and alloyed steels, including cast iron and manganese steels. The medium hard deposits will resist impact, yet give good abrasive wear resistance. Has good arc stability and produces a smooth, high crowned weld deposit. Deposits are not machinable or forgeable. Excellent for out-of-position field work.

APPLICATIONS:

To be used on most steels and cast iron. For medium hard overlays on new and used parts that must resist high abrasion and some impact. Used in construction, quarry mining and agriculture, for edges on buckets, scraper pan cutters and sides, feeder screws, mixer chutes, fan blades, crusher rolls and mill hammers.

TECHNICAL DATA:

Hardness	As Welded: up to 48-53 HRC
Polarity	AC or DC reverse (electrode +)

Diameter	Amperage
1/8” (3.2mm)	100-130
5/32” (4.0mm)	120-175
3/16” (5.0mm)	140-200

PROCEDURE:

Remove any fatigued or work hardened surface metal using MG 570. MG 755, a medium alloy electrode, is easy to deposit in either stringer beads or by weaving. This alloy is especially designed for flat or horizontal work, but also works well out of position. Usually two or more layers are recommended. Avoid overheating manganese steel base metals. When applying over soft base metals (below HRC 25), a cushion of either MG 740 or MG 600 is recommended.