MG 765W

Superior high alloy flux cored wire with excellent abrasion and good impact resistance.

MESSER MG Welding Products

GENERAL CHARACTERISTICS:

MG 765W is designed for use on carbon and low alloy steels, manganese steels and cast iron. Deposits take on a high polish, which contributed to high friction and abrasion wear resistance, especially against small particle abrasion. Excellent on applications that need impact as well as abrasion resistance. No shielding gas needed.

APPLICATIONS:

MG 765W is recommended for severe abrasion applications, along with moderate impact. This alloy also has good hot hardness up to approximately 1,000°F. Especially designed for crusher applications. Used heavily in construction, mining, brick and clay industries on parts such as crusher rolls, jaw crushers, bucket teeth edges, hammers, mill hammers, conveyor screws.

TECHNICAL DATA:

Hardness	57-61 HRC
Polarity	DC reverse (electrode +)

Recommended Range			
Diameter	Amperage	Volts	Wire Stick Out
.045” (1.2mm)	100-190	26-30	1”-2”
1/16” (1.6mm)	175-275	26-30	1 1/2”-2”
7/64” (2.8mm)	275-425	30-35	2”-3”
Optimum Range			
Diameter	Amperage	Volts	Wire Stick Out
.045” (1.2mm)	140	28	1 1/4”
1/16” (1.6mm)	225	28	1 3/4”
7/64” (2.8mm)	350	32	2 1/2”

PROCEDURE:

Remove any fatigued or unsound metal with MG 570. According to the thickness of deposit and type of base metal, a padding of MG 740, MG 750, or MG 600 might be considered, and a cushion of MG 200 is recommended on cast iron. Prevent excessive heat build-up. Allow parts to cool slowly.