MG 765

Severe abrasion, mild impact resisting surfacing electrode

MESSER MG Welding Products

GENERAL CHARACTERISTICS:

MG 765 is designed for use on carbon and low alloy steels, manganese steels and cast iron. Deposits take a high polish, which contributes to high friction and abrasion wear resistance, especially against small particle abrasion. Excellent on applications that need impact as well as abrasion resistance. Deposits well out of position.

APPLICATIONS:

MG 765 is recommended for severe abrasion applications, along with moderate impact. This alloy also has good hot hardness up to approximately 1000°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, etc.

TECHNICAL DATA:

Hardness	As welded: up to 57-61 HRC
Polarity	AC or DC reverse (electrode +)

Diameter	Amperage
3/32” (2.4mm)	75-110
1/8” (3.2mm)	90-130
5/32” (4.0mm)	120-170
3/16” (5.0mm)	140-200
1/4” (6.4mm)	200-250

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. On cast iron, a base of MG 200 is recommended. Deposits can be applied as stringer beads; however, weave passes are recommended for maximum deposition rate. Prevent excessive heat build-up. Allow parts to cool slowly.