

# MG 769

**Wearfacing electrode for moderate abrasion & impact**



## GENERAL CHARACTERISTICS:

General purpose surfacing alloy for surfaces subjected to abrasive wear and impact. Special alloying and fluxing agents produce the ultimate porous-free, high density, crack resistant weld deposit.

## APPLICATIONS:

Build-up and surfacing of new and worn machine parts of steel, and cast steel. An excellent product to use on earth moving and rock crushing machinery parts. Excellent for out-of-position application.

## TECHNICAL DATA:

Hardness	As Welded: up to 54-58 HRC
Polarity	AC or DC reverse (electrode +)

Diameter	Amperage
1/8" (3.2mm)	100-140
5/32" (4.0mm)	140-180
3/16" (5.0mm)	180-230

## PROCEDURE:

Remove foreign material and unsound metal from surface to be welded. Build surface using either stringer or weave beads. Select the current and amperage that gives puddle control, consistent with the thickness of material and position.

