

MG 770

**Superior high alloy for severe abrasion
with light impact**



GENERAL CHARACTERISTICS:

High deposition rate electrode that produces smooth beads with self-releasing slag. The high chromium content makes weld deposits maintain abrasion resistance even at elevated temperatures.

APPLICATIONS:

Parts subjected to severe abrasion but with light impact such as equipment for processing soil, rock, coal, cement, ceramic matter, grinding plates, dredger teeth, conveyor and press screws, coal augers, agitators, earth augers and scrapers. Also for surfaces that must resist abrasion combined with scaling such as open-hearth tools, grates, conveying chains in annealing furnaces and manipulators.

TECHNICAL DATA:

Hardness	As Welded: up to 56-60 HRC
Polarity	AC or DC reverse (electrode +)

Diameter	Amperage
1/8" (3.2mm)	80-125
5/32" (4.0mm)	100-160
3/16" (5.0mm)	125-190

PROCEDURE:

Remove foreign material and unsound metal from surface to be welded. For best results and long service life an elastic cushion layer should be applied to the part before surfacing with this electrode. Use MG 740 for a cushion layer on carbon steels and manganese steels; on cast iron use MG 200. When making the final surface with MG 770 keep electrode vertical to the workpiece and maintain a short arc. Deposits must be kept thin, never more than two layers thick. To prevent excessive local heat build-up in the part, alternate welding area. Allow part to cool slowly.

