

MG 770W

Hard surfacing self-shielded flux cored wire for severe abrasion



GENERAL CHARACTERISTICS:

MG 770W is a premium, quality high chromium hardfacing alloy designed to fight wear in high abrasion and erosion situations. Its ease of use and dilution tolerance make it a valued part of any maintenance and repair arsenal, even when wear occurs at high temperatures.

APPLICATIONS:

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

TECHNICAL DATA:

Hardness	56-60 HRC
Polarity	DC reverse (electrode +)

Recommended Range			
Diameter	Amperage	Volts	Wire Stick Out
0.045" (1.2mm)	180-230	24-28	3/4"
1/16" (1.6mm)	210-275	26-30	1 1/2"-2"

PROCEDURE:

Remove foreign material and unsound metal from surface to be welded using MG 570. For best results and long service life, an elastic cushion layer should be applied to the part before surfacing with this electrode. Use MG 740W for a cushion layer on carbon steels and manganese steels; on cast iron use MG 200W. Deposits must be kept thin, never more than two layers thick. If possible allow part to cool slowly.

