

# MG 790

**For severest fine particle abrasion resistance**



## GENERAL CHARACTERISTICS:

Smooth running electrode composed of Chromium, Tungsten, Molybdenum. It produces a flat weld with a very high deposition rate. Deposits are highly resistant to abrasion and erosion, even at elevated temperatures, up to 1600°F. Stable arc when using alternating current. Clearly visible metal pool, minimal slag. The 240% deposition rate ensures economic welding.

## APPLICATIONS:

Wear and abrasion resistant welds for hard-surfacing machine components subject to extremely high abrasion by sand, gravel, ore, coal, cement, slag, etc. Due to high abrasion resistance at elevated temperatures this electrode is also suitable for hardfacings on crushers, grates, conveyors for hot (glowing) coke, slag, cement and sinter-handling equipment.

## TECHNICAL DATA:

Hardness	As Welded: up to 63-65 HRC
Polarity	AC or DC reverse (electrode +)

Diameter	Amperage
1/8" (3.2mm)	140-170
5/32" (4.0mm)	180-220
3/16" (5.0mm)	230-300

## 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. Build-up a maximum of 3 passes. Manganese steels should not be preheated, and the part temperature kept below 550°F. Crack sensitive materials must be preheated to 500°F-700°F.

**Also available as a flux cored wire.**

