

MG 790W

For severe fine particle abrasion resistance at high temperatures



GENERAL CHARACTERISTICS:

Flux-cored, open-arc wire composed of Chromium, Tungsten, and Molybdenum. Deposits are highly resistant to abrasion and erosion, even at elevated temperatures, up to 1600°F. Clearly visible weld pool, minimal slag. Best results are achieved with a limit of two layers.

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 high temperatures this wire is also suitable for hardfacings crushers, grates, conveyors for hot (glowing) coke, slag, cement and sinterhandling equipment. Welds can be machined by grinding only.

TECHNICAL DATA:

Hardness	As Welded: up to 62-64 HRC
Polarity	DC reverse (electrode +)

Recommended Range			
Diameter	Amperage	Volts	Wire Stick Out
0.045" (1.2mm)	120-160	24-30	1"-2"
1/16" (1.6mm)	210-275	26-30	1.5"-2.5"
7/64" (2.8mm)	275-375	28-32	2"-3"

PROCEDURE:

Remove all foreign or damaged material from the weld area. Welding should be done in either the flat or horizontal position. Crack sensitive materials must be preheated to 500°F-700°F (400-500°C). Manganese steels should not be preheated and the bulk temperature kept below 550°F (288°C). Avoid fast heating or cooling, especially in highly hardenable steel. Slag can be welded over. Do not deposit more than two layers on top of each other. Where high build-up is necessary, fill first with MG 740, 750, or MG 600.

