

# MG 799

**Corrosion and heat resisting abrasion and frictional wear resisting self fluxing on most steels**



## GENERAL CHARACTERISTICS:

Easily applied as a gas brazing alloy with excellent corrosion resistance. The wide plastic range enables the deposit to be formed or shaped. A smooth finish helps reduce finishing costs. This very versatile alloy can be used as an arc rod on DC reverse polarity and with TIG on DC straight polarity.

## APPLICATIONS:

Excellent for metal-to-metal wear applications. Used where hardness is needed at higher temperatures such as valve faces, core drills, scrapers and wire straightening shoes; for cams, bushings and augers. Extensively used on cane knives and chemical pump sleeves.

## TECHNICAL DATA:

Hardness	As Welded: up to 56-62 HRC
Flame Adjustment	Neutral
Bonding Temperature	Approx. 1800°F
Polarity Arc	DC reverse (electrode +)
Polarity TIG	DC straight (electrode -)

Diameter	Amperage Arc	Amperage TIG
1/8" (3.2mm)	100-130	80-110
3/16" (5.0mm)	140-175	110-150

## PROCEDURE:

The area to be overlaid should be clean. Remove any surface oxidation by grinding or grit blasting. Use a neutral flame to preheat the start of the work area up to a sweat or brazing heat (just before red starts to show), apply a small amount of MG 799 and wet or tin the surface, then add more alloy to build-up using a bead-forming technique. MG 799 is self-fluxing on most applications. If you require a flux, use MG 130PF flux. Try to cool as slow as possible. Grind to finish.

