

MG 710

**ELECTRODE FOR BUILD-UP AND
REPAIR OF ALL "WATER", "OIL",
AND "AIR" HARDENING STEELS
AC OR DC EITHER POLARITY**

GENERAL CHARACTERISTICS:

Unique alloy formulation makes this electrode outstanding for the repair of all three types of heat treatable steels. Deposits are highly crack resistant, forgeable and temperable. Any number of passes can be made. Furthermore, repairs can be made in all positions.

APPLICATIONS:

Ideal for repair and build-up of shearing blades, planer plates, anvils, wood-working tools, percussion drills, earth borers, pressure rollers, clamping tools, worm conveyors, mixer arms, rollers, shovel and dredger teeth, crusher jaws and rings. Also for machine parts of steel and manganese steel which are subjected to grinding wear combined with strong impact.

TECHNICAL DATA:

Hardness	as welded 55-60 RC		
Current	AC or DC either polarity		
Amperage	45-90	80-120	110-160
(in)	3/32"	1/8"	5/32"
(mm)	2.5	3.25	4.0

PROCEDURE:

Clean weld area. In general it is not necessary to preheat, but if the base metal is highly carbonized it should be preheated to approx. 390°F (200°C). Build part to desired shape by using as many passes as necessary. Heat to a bright red; forge and grind to required dimension. Heat-treat and harden as you would for the base metal upon which the weld was applied. Final tolerances may be obtained by grinding.