

FERRITE BALANCED ALLOY FOR ALL STEELS GIVING SUPER STRENGTH



- Provides exceptional strength
- A non-cracking alloy for all steels
- Special "Ionized Arc Transfer" drastically reduces spatter and electrode overheating
- Deposit chemistry gives high crack-resistance
- Special flux coating elimination slag inclusion.
- Unique self peeling slag in most position, Thus reducing cleaning time which is welders appeal



MF 100

SPECIAL BENEFITS

- **MF 100 ALL STEEL** Ferrite Balanced Super-Strength Non- Cracking Alloy for All Steels ideal for maintenance welding.
- **MF 100** welds any dissimilar steel combinations.
- **MF 100 ALL STEEL** is ideal for all-position repairs of worn parts
- **MF 100** is ideal as an underlay for hardfacing.
- **MF 100 ALL STEEL** provides special "Ionized Arc Transfer" that drastically reduces spatter and electrode overheating, especially on small AC machines.
- **MF 100 ALL STEEL** is coated with a special flux formulation that eliminates slag interference in horizontal fillets.

OUTSTANDING PROPERTIES

- Special flux formulation eliminates slag inclusions in horizontal fillets.

APPLICATIONS

MF 100 ALL STEEL (for AC & DC) provides welds of excellent quality on the following metals:

Spring Steel	High-Carbon Steel
Stainless Steel	Shock-Resisting Steel
Sulphur-Bearing Steel	Vanadium Spring Steel
Galvanized Steel	Manganese Steel
Tool and Die Steel	Cast Steel



**MF 100 - FERRITE BALANCED ALLOY FOR ALL STEELS
GIVING SUPER STRENGTH**



MF 100

The ultimate electrode for welding all types of steels.

MF 100 ALL STEEL is the superior alloy for all steels that:

- Provides smooth arc and constant weld profile with self peeling slag is a welder choice
- No undercutting, overlapping or piling up.
- Provides a smooth, regular well-formed bead.
- Uniform in cross-section.

RECOMMENDED FOR:

Due to exceptional strength and crack resistance, it is ideal for repairing tools, dies, spring steel and any dissimilar metal combinations, except for aluminum and copper alloys. It is also recommended for repairing worn parts and as an underlay for hardfacing.



**MF 100 - FERRITE BALANCED ALLOY FOR ALL STEELS
GIVING SUPER STRENGTH**



MF 100

MECHANICAL PROPERTIES:

Undiluted Weld Metal

Tensile strength as welded

Work hardened

Yield strength

Elongation

Reduction of area

Impact Energy

Hardness

Maximum Value up to:

128,000 psi (880 N/mm²)

186,000 psi (1280 N/mm²)

90,000 psi (630 N/mm²)

32%

25%

50J: 68°F (20°C)

Brinell 225

RECOMMENDED CURRENT:

DC reverse polarity (Electrode +) or AC

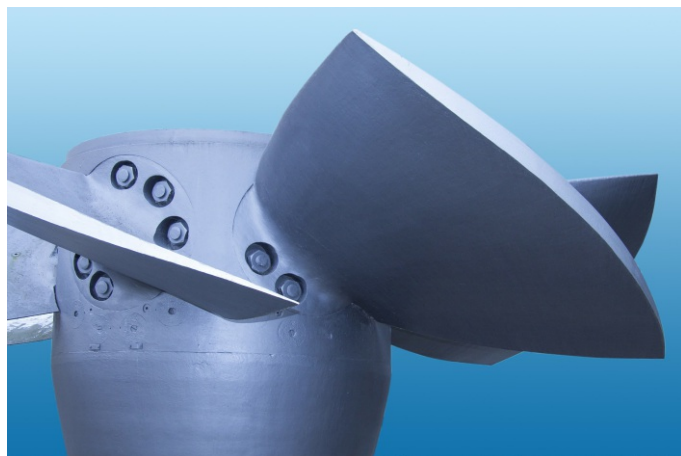
RECOMMENDED AMPERAGE SETTINGS:

Diameter in (mm)	1/16 (1.6)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)	5/32(4.0)	3/16 (5.0)
Minimum Amperage	25	30	35	60	75	130
Maximum Amperage	35	55	70	110	140	200

WELDING POSITION: Flat, Horizontal, Vertical up, Overhead

WELDING TECHNIQUES:

The area in which the weld is to be made should be free of rust, grease & grit, paint and other materials



MF 100 - FERRITE BALANCED ALLOY FOR ALL STEELS
GIVING SUPER STRENGTH

