

MF 105



EXTRA-LOW HYDROGEN MOISTURE RESISTANT ALLOY FOR HIGH STRENGTH STEEL

- Engineered specially for welding high-strength low alloy steels
- Suitable for unalloyed construction steels
- Better crack resistance even without preheating
- Superior moisture-resistance



MF 105

SPECIAL BENEFITS

- **MF 105** is quality engineered specially for outstanding results even on the most difficult-to-weld steels, including high-strength low-alloy steel
 - **MF 105** offers outstanding mechanical properties
 - **MF 105** provides superior crack resistance without preheating in some cases
 - **MF 105** enables you to weld higher tensile strength steels
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OUTSTANDING PROPERTIES

- A unique low hydrogen alloy made in 1/16 (1.6mm) size
 - Extremely smooth, Arc with good Arc stability
 - Unusually good AC welding characteristics
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APPLICATIONS

- **MF 105** is the right choice for welding low-alloy high-tensile construction steels.
- **MF 105** has the potential for AC & DC applications
- **MF 105** also has superior welding properties when welding all types of steel
- **MF 105** gives goods results on some problem steel such as: Rusty Steel, Sulfur-Bearing Steel Alloys, Free-Machining Steel, Cold Rolled Steel

Low Hydrogen steel electrode for unalloyed construction steels

- Mf105 has self-annealing quality to eliminate under-bead cracking and similar metallurgical Discontinuities
- It gives good deposition rate
- The weld is fully machinable

RECOMMENDED FOR:

Joining and repairing boiler plate, pipe steels, shipbuilding steels and cast steels.
Excellent for weather and corrosion resistant steels like as COR-TEN®.

**MF - 105 EXTRA-LOW HYDROGEN MOISTURE
RESISTANT ALLOY FOR HIGH STRENGTH STEEL**



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MECHANICAL PROPERTIES:

Undiluted Weld Metal

Tensile Strength

Yield Strength

Elongation

Impact Energy

Maximum Value Up to:

84,000 psi (610 N/mm²)

69,000 psi (500 N/mm²)

32%

90J: -30°C

RECOMMENDED CURRENT: DC Reverse (+) or AC

RECOMMENDED AMPERAGE SETTINGS:

Diameter in (mm)	1/16 (1.6)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	30	65	140	100	190
Maximum Amperage	45	100	190	140	250

WELDING POSITIONS: All position

WELDING TECHNIQUES:

Remove all surface contaminants. Maintain a short arc gap and use a stringer technique. Chip slag thoroughly between passes.

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