

SUPER TOUGH ALLOY FOR HIGH STRENGTH STEEL



- Unique "Double Coated" low hydrogen electrode excels at AC welding
- Engineered specially for the welding of high-strength low alloy steels.
- The "Low Hydrogen" electrode that can easily be used on low open circuit voltage welders
- Outstanding mechanical properties.



MF 108

SPECIAL BENEFITS

- **MF 108** Super- Tough Alloy for High-Strength Steels Enables you to weld steels with higher tensile strength
 - **MF 108** is quality engineered specially for outstanding results even on the most difficult-to-weld steels, including high-strength low-alloy steels
 - **MF 108** offers superb mechanical properties
 - **MF 108** provides superior crack resistance, on some jobs even without preheating
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OUTSTANDING PROPERTIES

- **MF108** Self can reduce under-bead cracking
 - **MF108** In some cases steels upto 0.4% and other treated steel can also be welder
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APPLICATIONS

- **MF 108** (for AC & DC) is the right choice for welding low- alloy high-tensile construction steels
- **MF 108** has superior welding properties

MF 108 Very unique "Double Coated" low hydrogen electrode

- Unique "Double" flux coating, helps for goods arc stability
- Superior crack resistance helps to weld some jobs without preheating
- Uniqe arc stability helps to weld even in root passes in positional welding

**MF 108 SUPER TOUGH ALLOY FOR
HIGH STRENGTH STEEL**



MF 108

MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	87,000 psi (630 N/mm ²)
Yield Strength	72,000 psi (520 N/mm ²)
Elongation	31%
Impact Energy	120J: -20°C

RECOMMENDED CURRENT: DC Reverse (+) or AC

RECOMMENDED AMPERAGE SETTINGS:

Diameter in (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	60	90	140	200
Maximum Amperage	90	135	190	260

WELDING POSITIONS: All position

WELDING TECHNIQUES:

Clean areas to be joined. Initiate arc and use conventional "stringer weld" technique.

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