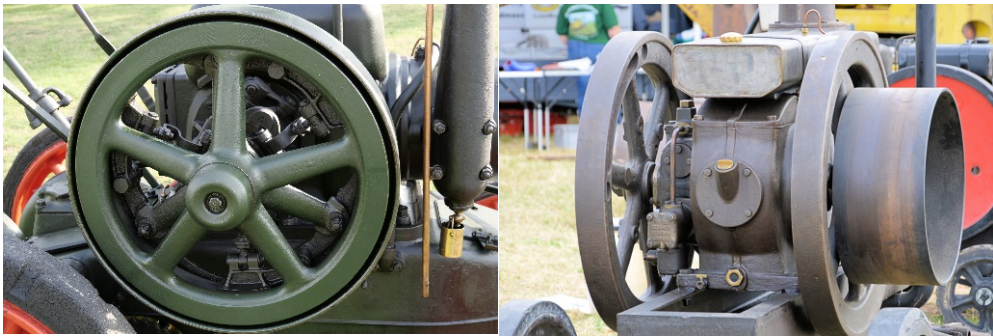


MF 300

SUPERIOR NICKEL - FREE ALLOY FOR DIRTY OR BURNED CAST IRON



- Suitable for greasy, rusty and burned cast iron
- Non-conductive flux coating
- Color & co-efficient of expansion closely match Cast Iron.

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MF-300

SPECIAL BENEFITS

- MF 300 Superior Alloy for Dirty or Burned Cast Iron is a nickel-free electrode
- MF 300's unique "Quick Freeze Action" means deposits solidify before defects and porosity has a chance to form
- MF300 welds successfully without preheat in some cases.

OUTSTANDING PROPERTIES

- A superior alloy for dirty or burned cast iron
- Is quality engineered to attain the best results possible when welding greasy, dirty and heat-affected cast iron
- Gives a perfect color match
- Having good elongations gives good match to cast iron

APPLICATIONS

- Furnace Gates
- Oil-Saturated Cast Iron
- Foundry Casting Repairs
- Ornamental Iron Fabrication
- Cast iron architectural applications
- Steel-to-Cast Iron Welding

MECHANICAL PROPERTIES:

Undiluted Weld Metal

Tensile Strength
Yield Strength
Elongation
Impact Energy
Hardness

Maximum Value Up to:

110,000 psi (750 N/mm²)
76,000 psi (530 N/mm²)
32%
50J: 68°F (20°C)
Brinell 219, Rockwell C 14

RECOMMENDED CURRENT: DC Reverse (+) or AC

RECOMMENDED AMPERAGE SETTINGS:

Diameter in (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	45	70	95
Maximum Amperage	85	125	150

WELDING POSITIONS Flat, & horizontal weld

WELDING TECHNIQUES:

Use stringer Bead technique. When cladding, cover the entire base surface prior to finish welding.

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