

MF 301

HIGH STRENGTH NON-CRACKING MACHINABLE ELECTRODE FOR CAST IRON



- Gives perfect machinable welds on practically all types of cast iron
- Barium-free flux coating eliminates hazardous fumes
- Has higher tensile strength than usual cast iron welding alloys



MF-301

SPECIAL BENEFITS

- MF 301 requires pre-heating for some jobs
- MF 301 is ideal for maintenance work in large plants
- MF 301 High-Strength Non-Cracking Machinable Electrode for Cast Iron
- MF 301 is an ideal maintenance electrode producing a machinable weld on cast iron
- MF 301's excellent elongation helps to prevent cracking of the weld
- MF 301 has a higher tensile strength than most types of cast iron welding alloys

OUTSTANDING PROPERTIES:

- Offers extremely high tensile strength
- Low viscosity slag enables to weld pass-on-pass without removing slag between passes
- Gives high-strength welds greasy on dirty cast iron

APPLICATIONS

MF 301 (for AC & DC) is the ideal maintenance electrode for use with

- Malleable Iron ● Meehanite ● Steel to Cast Iron
- Ductile Iron ● Grey Iron

**Nickel - iron "Barium Free" electrode for joining dirty
contaminated
cast irons and cast irons to steel**

- Extremely strong arc penetrates surface contaminants
- Special slag composition can reduce porosity on dirty job
- Extra nickel content ensures crack resistant machinable welds

**MF - 301 HIGH STRENGTH NON-CRACKING
MACHINABLE ELECTRODE FOR CAST IRON**



MF-301

MECHANICAL PROPERTIES:

| Undiluted Weld Metal | Maximum Value Up to: |
|-----------------------------|--|
| Tensile Strength | 70,000 psi (500 N/mm ²) |
| Yield Strength | 49,000 psi (350 N/mm ²) |
| Elongation | 20% |
| Hardness | Rockwell B 88-90, Brinell 180, Vickers 189 |

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 | 50 | 70 | 100 | 130 |
| Maximum Amperage | 80 | 110 | 140 | 175 |

WELDING POSITIONS: Flat, & Horizontal

WELDING TECHNIQUES:

Remove any surface contamination with the proper solvents. Adjust the welding machine to the lowest proper setting that yields good welding conditions.

RECOMMENDED FOR:

Universal electrode for joining a wide variety of ductile, nodular and malleable cast irons. Ideally suited for the repair of meehanite dies.

