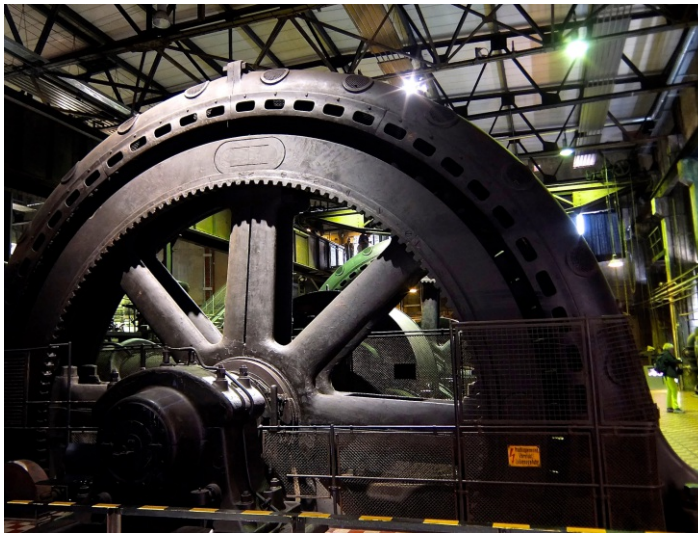


MF 302

SUPERIOR “Tri-metal” CORED ELECTRODE FOR CAST IRON



- Superior “Tri-Metal Core” design eliminates electrode overheating
- Burns off surface contaminants before weld metal transfer
- Unique deposit chemistry yields the ultimate combination of softness, ductility and tensile strength



MF-302

SPECIAL BENIFITS

- **MF 302** is a Machinable Electrode for Cast Iron
 - **MF 302's** ability to weld virtually all types of cast iron enables users to reduce their maintenance stock leading to lean maintenance
 - **MF 302's** high-tech "controlled blast" pulse action automatically degreases and cleans oily cast iron, while burning off surface contaminants including scaling and oxides before weld metal transfer
 - **MF 302** eliminates electrode overheating - even under the most difficult AC amperage loading conditions
-

OUTSTANDING PROPERTIES

- **MF 302** : Prevents martensitic formation for improved machinability
 - **MF 302** : Unique flux coating with rutile provides goods arc stability
 - **MF 302** : Small parts may not required Pre- heating but for bigger components it is advisable to free heat up to 250°C -300°C
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APPLICATIONS

- **MF 302** (for AC & DC) is the most versatile cast iron electrode providing a universal solution to the difficult problem of cast iron welding. It is the long awaited "Welders' Choice" for virtually all types of cast iron -including joining cast iron parts to steel.
- **MF 302** can be used on grey, nodular and malleable cast iron. It is also used to weld ductile iron, "Ni-Resist" and "Meehanite" and provides good weldability of nickel alloys.
- Visually unique core wire gives outstanding benefits
- High efficiency weld metal transfer totally eliminates electrode overheating
- Proprietary copper-nickel-iron deposit chemistry yields the ultimate combination of softness, ductility and tensile strength

**MF - 302 SUPERIOR "Tri-metal" CORED ELECTRODE
FOR CAST IRON**



MF-302

MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	77,000 psi (550 N/mm ²)
Yield Strength	54,000 psi (380 N/mm ²)
Elongation	30%

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	50	70	100
Maximum Amperage	70	100	130

WELDING POSITIONS:

All position in some cases, depends upon components size & design

WELDING TECHNIQUES:

Guide the electrode at a steep angle keeping the arc length short.
Use short staggered beads when welding restrained parts.

**MF - 302 SUPERIOR "Tri-metal" CORED ELECTRODE
FOR CAST IRON**

