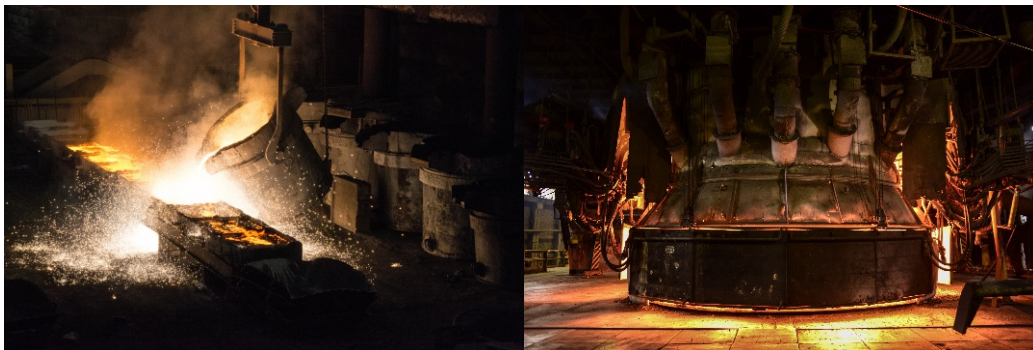


# MF 401

## PROBLEM SOLVER FOR HASTELLOY® MATERIALS



- Excellent for elevated temperature applications
- Offers wear resistance but is entirely machinable
- Excellent corrosion resistant welding alloy
- Weld appearance are exceptional

**Welds can withstand temperature extremes ranging from  
-140°F to 1900°F (-95°C to 1040°C).**



# MF-401

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## SPECIAL BENEFITS

- MF 401 Nickel-based Electrode for Hastelloy® Materials
  - MF 401 for excellent hardness retention at elevated temperatures
  - MF 401 gives excellent resistance to corrosion
  - MF 401 is an ideal "Problem Solver"
  - MF 401 Nickel-based Electrode for Hastelloy® Materials
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## OUTSTANDING PROPERTIES:

- Is especially good in applications like corrosion resisting, a particular pitting stress corrosion cracking too
  - Can be forged
  - Provides superb weld-ability
- 

## APPLICATIONS

**MF 401** (AC & DC) is perfect for joining as well as overlaying high nickel alloys such as: Hastelloy® Alloys, Inconel®, Monel®, Dissimilar Nickel Alloys

**MF 401** is the ideal solution for

- |                           |                      |                         |
|---------------------------|----------------------|-------------------------|
| ● Steel Mill Billet Tongs | ● Valves & Pipelines | ● Acid & Chemical Tanks |
| ● Crane Tong Bits         | ● Hot Trimmer Dies   | ● Hot Shear Blades      |
| ● Sizing Punches & Rings  | ● Mill Guides        | ● Piercing Tools        |
| ● Shafts                  | ● Rams               | ● Ladles                |

## RECOMMENDED FOR:

For joining and cladding most nickel alloys, stainless steels, and carbon steels. Excellent for oxidation and corrosion resistant applications.

**MF 401 PROBLEM SOLVER FOR  
HASTELLOY® MATERIALS**



# MF-401

## MECHANICAL PROPERTIES:

### Undiluted Weld Metal

### Maximum Value Up to:

Tensile Strength	136,000 psi (950 N/mm <sup>2</sup> )
Yield Strength	95,000 psi (660 N/mm <sup>2</sup> )
Elongation	40%
Impact Energy	65J: -320°F (-195°C)
Hardness	Brinell 238, Rockwell C22
Work Hardness	Brinell 428, Rockwell C45

## 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	70	100	130
Maximum Amperage	95	135	175

## WELDING POSITIONS: Flat, Horizontal

### WELDING TECHNIQUES:

Weld with lowest amperage feasible using a very short arc gap.  
Welds can be deposited using the stringer  
good sound welds can be obtain can be  
achieve using the stringer beads

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