

MF 604

ELECTRODE FOR EXTREME ABRASION RESISTANT SURFACES



- Smooth deposits offer a fantastic combination of abrasion resistance and temperature hardness retention
- Special Chromium Carbide coated electrode for abrasion and medium impact
- Withstands even the most severe grinding abrasion

SPECIAL FEATURES

- **MF 604** Hardfacing Electrode for Extreme Abrasion resistance
- **MF 604** withstands even the most severe grinding-type abrasive action
- **MF 604** is self-peeling with optimum current of slag
- **MF 604** coatings can be very thin
- **MF 604** enables quick repair.
- **MF 604** promotes re-use of worn out parts



MF-604

OUTSTANDING PROPERTIES:

- Is coated with chemical flux that contains special arc stabilizers
- Is made of a special alloy in base, rather than mild steel tube, for improved results and reliability
- Saves costly downtime -extends working life of machinery

MF 604 - All position chromium carbide electrode for abrasion and medium impact

- Thinner than normal coating allows for ease of use out of position
- Molten metal is viscous and easy to control
- Slag is not a problem

RECOMMENDED FOR:

MF 604 general overlaying on construction and mining equipment, where you need a super hard surface that stands up to even the most severe abrasion.

MECHANICAL PROPERTIES:

Undiluted Weld Metal

Hardness
Wear Co-efficient

Maximum Value Up to:

Brinell 600, Rockwell C57-59
1.9%

RECOMMENDED CURRENT: AC/DC (+)

RECOMMENDED AMPERAGE SETTINGS:

Diameter in (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	viable 90	140	180
Maximum Amperage	120	170	220

WELDING POSITIONS: Flat, Horizontal, Vertical up, on sum jobs

MF-604 Large diameter --Low Amperage Tubular Hardfacing Electrode is available on confirm order.

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RESISTANT SURFACES**

