

## HIGH BUILD-UP ELECTRODE THAT RESISTS EXTREME COMPRESSIVE STRESSES



- Very tough alloy –fully machinable
- Excellent for flame hardening
- Outstanding weld-ability gives non-cracking deposits even on heavy overlays
- For Buffer Layer on carbon and low alloy steels

### OUTSTANDING PROPERTIES:

- Can be used as a buffer layer on large components before hardfacing electrodes are applied
- Welding alloy with multi-pass facility without need for chipping slag
- Provides outstanding compressive strength



# MF-605

## SPECIAL BENEFITS

- **MF 605** Superior Build-Up electrode that extends the working life of Component
- **MF 605** Gives super tough, fully machinable welds on parts needed for prolonged service after machining
- **MF 605** Provides outstanding weld-ability -gives fast non-cracking deposits even on heavy overlays and thick build-ups

## High build-up electrode depositing weldmetal that resists extreme Compressive stresses

- Semi-hard and machinable deposit for rebuilding and surfacing
- Excellent machinability
- Can be applied as a cushioning layer prior to hardfacing
- Works well vertical and horizontal position on some jobs
- Excellent for overlaying even high-carbon or low-alloy steels where cracking can be a problem

## RECOMMENDED FOR:

- Tractor Shoes
- Concrete Mixer
- Clutch Faces
- Mine Car Wheels
- Shafts
- Blades
- Gear Teeth
- Well Drill Bits
- Jack Bits
- Roll Ends
- Shafts
- Drive Sprockets
- Rollers Rails
- Bosses
- Chains and wheels

## MECHANICAL PROPERTIES:

Undiluted Weld Metal  
Hardness:

Maximum Value Up to:  
Rockwell C 25-27 Brinell 270

**RECOMMENDED CURRENT:** DC Reverse (+), or AC

## RECOMMENDED AMPERAGE SETTINGS:

Diameter in (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	100	140	180
Maximum Amperage	140	180	230

**WELDING POSITIONS:** Flat, Horizontal

## WELDING TECHNIQUES:

Weld with stringer bead fashion. When welding vertically use the "whip" technique.

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