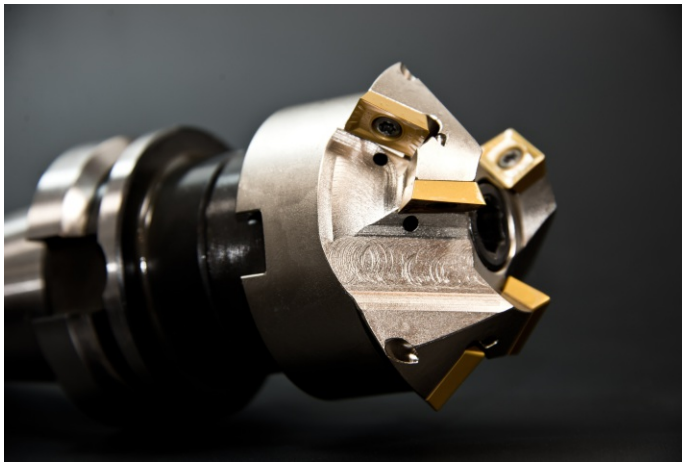


MF 606

EXTREMELY SMOOTH RUNNING ELECTRODE FOR HIGH - SPEED STEEL



- Ideal for high-speed Steel cutting
- Retains cutting edge sharpness
- Withstands more shock
- High percentage of cobalt gives super performance
- Meant for the tool stores



MF-606

SPECIAL BENEFITS

- **MF 606** High-Speed Cobalt Base Electrode is meant for maintenance work
- **MF 606** Is highly alloyed for superior performance
- **MF 606** Gives sharp edge formations
- **MF606** Deposits are ideal for cutting edges.
- **MF 606** Withstands extreme shock loads

OUTSTANDING PROPERTIES:

- Gives hardness as applied to 58 Rockwell C
- Good hardness at elevated temperatures
- Requires no heat-treating -but can be heat-treated if necessary
- Reduces tooling costs -cutting tools can now be made of low-cost machinable steels
- Reduces inventory of expensive tools -special tools can be quickly made and repaired

MF 606 - Extremely smooth running Alloy 12 Cobalt electrode

- Excellent resistance to metal abrasion.
- Self peeling Slag
- Weld deposits are unusually fine rippled and uniform.
- AC and DC possibility.

RECOMMENDED FOR:

MF 606 is the unique alloy for long- wearing cutting edges.

- Milling Cutters Broaches
- Lathe Tools
- Shear Blades
- All types of Cutters
- Extrusion nozzles
- Scrapers
- Drilling and Boring Tools
- Punches
- Forging tools

**MF - 606 EXTREMELY SMOOTH RUNNING
ELECTRODE FOR TOOL STEEL**



MF-606

MECHANICAL PROPERTIES:

Undiluted Weld Metal

Room Temperature:

Work Hardened

Elevated Temperatures:

Maximum Value Up to:

Hardness

68°F (20°C) Rockwell C50

Rockwell C58

750°F (400°C) Rockwell C44

1110°F (600°C) Rockwell C40

1475°F (800°C) Rockwell C37

1620°F (900°C) Rockwell C35

RECOMMENDED CURRENT: AC or DC Reverse (+)

RECOMMENDED AMPERAGE SETTINGS:

Diameter in (mm)	3./32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	65	80	100
Maximum Amperage	85	110	130

WELDING POSITIONS: Flat, horizontal

WELDING TECHNIQUES: Preheat heavy parts to 570°F (300°C).

**MF - 606 EXTREMELY SMOOTH RUNNING
ELECTRODE FOR TOOL STEEL**

