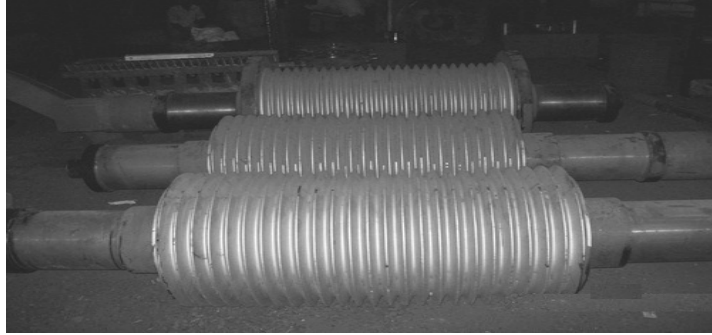


MF 609

GRIP RESISTANCE CHROMIUM CARBIDE ELECTRODE



- Hardfacing Graphite Cast Iron Rollers in Sugar Mills
- Protect against severe abrasive wear and moderate impact.
- Ripple free surface doubles "grip resistance" to fine abrasive media.
- Special formula totally eliminates the "Worm Tracking" type porosity common to this alloy group.



MF-609

SPECIAL BENEFITS

- **MF 609** Available as a Special Tubular MIG Wire.
 - **MF 609** Totally eliminates the "Worm Tracking" type porosity common to this alloy group.
 - **MF 609** Chromium carbide electrode for economical smooth overlays.
-

OUTSTANDING PROPERTIES

- Specially design for Graphite Cast Iron Rollers in the Sugar Industry.
 - Protects most iron base surfaces against severe abrasive wear and moderate impact
-

APPLICATIONS

- Roughening Cast Iron Rollers in Sugar Mills
- Excavator Buckets Lips & Teeth
- Austenitic Manganese Steel.
- Iron Based Surfaces.

"GRIP RESISTANCE" CHROMIUM CARBIDE ELECTRODE

- Protect against severe abrasion and moderate impact.
- Ripple free surface doubles "Grip Resistance" to fine abrasive media

**MF 609- "GRIP RESISTANCE" CHROMIUM
CARBIDE ELECTRODE**



MF-609

MECHANICAL PROPERTIES:

Undiluted Weld Metal

Maximum Value Up to:

Hardness:

Rockwell C 52-59

Wear Co-efficient

Vickers 565-727

2 %

RECOMMENDED CURRENT: DC Reverse (+) or AC

RECOMMENDED AMPERAGE SETTINGS:

Diameter in (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	65	110	160	210
Maximum Amperage	95	140	200	270

Settings:

.045" (1.2mm) D.C.R.P., 18-30 Volts, 125-250 Amps

Mig Wire

1/16" (1.6mm) D.C.R.P., 20-30 Volts, 150-300 Amps

WELDING POSITIONS: Flat, Horizontal (smaller diameters can be used out of position)

WELDING TECHNIQUES:

Allways used stringer beads for good weld profile.

Deposit a maximum of 2 to 3 passes to achieve full hardness..



MF 609- "GRIP RESISTANCE" CHROMIUM
CARBIDE ELECTRODE

