

MF 704

EXCELLENT ELECTRODE WITH SUPER WEAR-RESISTANCE FOR COPPER ALLOYS



- Ideal for overlaying steel or cast iron
- Joins a wide variety of dissimilar metals
- Provides outstanding weldability
- Nickel Manganese Aluminum Bronze Electrode With Excellent Wear Resistance



MF 704

SPECIAL BENEFITS

- **MF 704** Provides outstanding weld-ability after build-up
- **MF 704** Joins dissimilar metals, such as steel to bronze
- **MF 704** Resists wear and corrosion
- **MF 704** Gives an entirely machinable weld
- **MF 704** Versatile Electrode for Copper Alloys
- **MF 704** Ideal for surfacing copper

OUTSTANDING PROPERTIES:

- It is a good choice for jobs where brazing is slow and expensive
- Application is good for cast iron, bronze, copper, steel, Stainless & in some cases for nickel
- Gives a low friction surface

APPLICATIONS

MF 704 The right choice for rebuilding worn parts.

- | | | |
|-------------------|---------------------------|----------------------------|
| ● Stainless Steel | ● Cast Iron | ● Steel |
| ● Malleable Iron | ● Galvanized Iron | ● Aluminum |
| ● Bronze | ● Copper | ● Brass |
| ● Monel | ● Some Naval Applications | ● ALCO Bronze Applications |



MF 704 - EXCELLENT ELECTRODE WITH SUPER WEAR-RESISTANCE FOR COPPER ALLOYS



MF 704

MF 704 Very High Strength Nickel Manganese Aluminum Bronze (Electrode) Giving Excellent Wear Resistance

- Universal electrode safely repairs all grades of aluminum bronzes
- Resists corrosion, cavitations, erosion and metal to metal wear

RECOMMENDED:

Joining and surfacing parts subject to service in marine environments and seawater.

MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	96,000 psi (650 N/mm ²)
Yield Strength	65,000 psi (450 N/mm ²)
Elongation	20%
Hardness	Brinell 155, Rockwell B87

RECOMMENDED CURRENT: DC Reverse (+)

RECOMMENDED AMPERAGE SETTINGS:

Diameter in (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	90	105	135
Maximum Amperage	130	155	210

WELDING POSITIONS: Flat

WELDING TECHNIQUES:

Preheat in some cases may be required for Bronze and copper.

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RESISTANCE FOR COPPER ALLOYS

