

MG "SUPER" 600

The ultimate electrode for welding all types of steels, without any danger of cracking or breakage



GENERAL CHARACTERISTICS:

"Super" 600 has been formulated to provide the best possible arc stability, even under adverse conditions. It is amazingly stable on low, open circuit voltage and AC buzz boxes. The weld metal transfer is especially smooth and there is almost no spatter and easy arc. We have even managed to make the slag virtually self-releasing. It is without a doubt the best possible product to use on unknown steels or dissimilar metal combinations.

APPLICATIONS:

Due to its exceptional strength and crack resistance, it is ideal for repairing tools, dies, spring steel, and any dissimilar metal combinations, with the exception of the aluminums and copper alloys. Because the weld metal is so tough, it is also recommended for repairing worn parts, and has an underlay for hardfacing. Because of its low amperage requirements and exceptional ease of use, it should be the first choice for both home hobbyists and maintenance welders for general applications.

TECHNICAL DATA:

Typical Tensile Strength	As Welded: up to 128,000 psi (883 N/mm ²)
	Work Hardened: up to 186,000 psi (1282 N/mm ²)
Typical Yield Strength	Up to 90,000 psi (621 N/mm ²)
Elongation	Approx. 32%
Hardness	Approx. 320 HB
Polarity	AC or DC reverse (electrode +)
	(Especially recommended for AC)

Diameter	Amperage
1/16" (1.6mm)	25-35
3/32" (2.4mm)	35-70
1/8" (3.2mm)	60-110
5/32" (4.0mm)	75-140
3/16" (5.0mm)	130-200

PROCEDURE:

The area in which the weld is to be made should be free of rust, grease, paint and other materials which cause weld contamination. A 90° vee joint should be used when joining heavy sections. Preheat is necessary only for high carbon steels, which should be preheated to 350°F (204°C), the interpass temperature should be kept below 500°F (260°C). Alignment should be maintained by the use of fixtures, tack welds or other types of mechanical support. Maintain a short arc length and use stringer beads. Avoid weaving whenever possible.

