

# MG 240

**Bare rod for brazing and oxy-fuel welding  
of cast irons**



## **GENERAL CHARACTERISTICS:**

MG 240 is a bare rod intended for the repair and joining of cast irons by oxy-fuel processes rather than conventional welding techniques. Deposits are easily machined and match castings in both color and rusting, making repairs virtually undetectable.

## **APPLICATIONS:**

Torch welding for maintenance and production of heavy and light castings. Commonly used on parts where color match is critical such as filling of surface defects and building up worn or missing sections. Also used to repair machine bases, manifolds, engine blocks, cylinder heads and gear housings.

## **TECHNICAL DATA:**

Typical Tensile Strength	40,000 psi (276 N/mm <sup>2</sup> )
Working Temperature	1600°F (870°C)
Hardness	Approx. 200 HB
Color Match	Excellent

## **PROCEDURE:**

Bevel heavy sections to form a 75° vee. Always use a slightly carburizing flame to prevent porosity due to oxidation of carbon. Preheat part to 800°F (430°C) before starting to weld. When using bare rods heat end of rod, dip in MG 240 flux and transfer to weld area. Melt off a small amount of rod, continue heating until deposit flows out. Add filler metal a drop at a time making sure each deposit is fused to the base metal; use sufficient flux for good cleaning and protection. After welding allow part to cool slowly to prevent hardening and cracking.