

MG 289

Maximum strength alloy for dirty cast iron
“the problem solver”



GENERAL CHARACTERISTICS:

Unique flux coating on alloyed core wire produces dense, strong, crack-resistant welds on all types of cast iron. Especially good for contaminated, old, oil-soaked, dirty base metal. Also recommended for joining cast iron to steel. Use on gray, ductile, Meehanite and nodular cast iron. Deposits are machinable. Also available in a wire.

APPLICATIONS:

Use on sewer pipe, machine bases, transmission or gear housings, sprockets, repair of or build-up on gears and any repair of cast iron to steel.

TECHNICAL DATA:

Typical Tensile Strength	Up to 75,000 psi (517 N/mm ²)
Hardness	Brinell 210
Polarity	AC or DC reverse (electrode +)

Diameter	Amperage
3/32" (2.4mm)	40-70
1/8" (3.2mm)	70-110
5/32" (4.0mm)	90-130
3/16" (5.0mm)	110-170

PROCEDURE:

On heavy sections, remove worn, cracked metal and bevel joint using MG 570 or a grinding wheel. On very heavy sections, preheat to approximately 400°F. Use short stringer beads for root pass and peen lightly after removing slag. Use a short to medium arc and the lowest amperage possible to minimize base metal overheating. When breaking arc, always back whip into weld crater. Weaving two times rod diameter is acceptable for cover beads on multi-pass work. Weld joints should be allowed to slow cool for maximum strength and machinability.

