



SUPERGOLD 002 MB

**High build-up electrode depositing
weld metal that resists extreme
compressive stresses**

- Very tough alloy for underlayments or medium hard tough overlays.
- Excellent machinability.
- Excellent in vertical and horizontal position welding.

Description:

Electrode with a semi-hard and machinable deposit for rebuilding and surfacing. The weld deposit is dense and resist deformation, compression and high impact.

Applied as cushion layer prior to hard facing, for buildup of worn parts like rails, drive sprockets, gear teeth, chains, and wheels.

Microstructure:

Martensite with some carbides.

Flux color:

Typical mechanical properties:

Undiluted Weld Metal

Hardness:

Maximum Value Up to:
Rockwell C 25-27 Brinell 270

Recommended current:

DC Reverse (+), or AC

Recommended amperage settings:

Diameter (mm)	3.15	4.00	5.00
Minimum Amperage	100	140	180
Maximum Amperage	140	180	230

Welding positions:

Flat, Horizontal, Vertical up

Welding techniques:

Weld in stringer or 3 X weave fashion. When welding vertically use the “ whip” technique.

Applications:

For underlayments on carbon and low alloy steels, also as a stand alone overlay for medium hard tough build-ups on rails, shafts, etc.