



AUTOMIG MC 42

MCAW (Hard facing)

ALLOY BASIS :

Cr, Mo, Ni, V

KEY FEATURES:

- Gas shielded metal cored wire
- Low alloy steel weld deposit
- Stable and smooth arc, no spatter
- No slag, smooth weld bead
- Weld deposit free from porosity
- Excellent resistance to metal to metal wear at high temperatures and thermal shocks
- Suitable for multi-pass crack free welding


TYPICAL APPLICATIONS:

- For surfacing and reclamation of large hot working dies specially drop and press forging dies, hot working tools
- Suitable for H11, H13, DIN 1.2714 and DB-6 die block material





MECHANICAL PROPERTIES OF ALL WELD METAL:

Condition	3 Layer Hardness, HRc, Typical
As Welded	43-47
Stress Relieved	44-48

PARAMETERS - PACKING DATA:

Ø , mm 1.60 2.40	Kg/Spool 12.5 12.5	 DCEP

Shielding Gas	Gas Flow Rate, LPM
80Ar+20CO ₂	18-25

Machinability	Metal to Metal WearResistance	Impact Resistance	Corrosion Resistance
			

Physical Properties: With increase in number of squares, property improves