

MG 500

Easiest-to-use, all position electrode for mild steel



GENERAL CHARACTERISTICS:

This electrode has been designed to operate on almost any AC or DC welding machine even when the open circuit voltage is very low. The special coating protects the weld deposit from adverse conditions normally encountered in maintenance repair welding. Low amperage requirement controls distortion when welding thin sheet metal; spatter is kept to a minimum. Ideal for field repair work and out-of-position welding.

APPLICATIONS:

Fabrication of thin, medium, heavy and dissimilar gauge mild steels. Sheets, plates, angle iron, beams, pipes and machine parts can be welded in all positions. Also used for filling holes and build-up of over-machined and worn surfaces. Commonly used on applications requiring short, intermittent and spot welds because of the outstanding restarting characteristics.

TECHNICAL DATA:

Typical Tensile Strength	Up to 80,000 psi (552 N/mm ²)
Typical Yield Strength	Up to 68,000 psi (469 N/mm ²)
Elongation	Approx. 24%
Polarity	AC or DC (+/-)

Diameter	Amperage
1/16" (1.6mm)	20-50
5/64" (2.0mm)	25-60
3/32" (2.4mm)	35-80
1/8" (3.2mm)	65-125
5/32" (4.0mm)	90-160
3/16" (5.0mm)	120-210

PROCEDURE:

Remove as much foreign material as practical from the weld area. DC reverse polarity (electrode +) produces deep penetration; DC straight polarity (electrode -) will have limited penetration and a flatter bead. AC prevents arc blow. A medium arc length should be maintained with either stringer or weave beads. Slag is easily removed with a light chipping hammer.

