MG 600

The strongest, problem solving, universal electrode for all steels

MESSER MG Welding Products

GENERAL CHARACTERISTICS:

A low heat input electrode designed to produce the highest tensile welds. It can be used in all positions to produce smooth, porosity free welds without undercut or spatter. Also available as a TIG and MIG wire.

APPLICATIONS:

Welding low, medium, and high alloy steels requiring the highest strength and quality. Ideal for repair of tools, dies, springs, carbon steels, stainless steels, pressure vessels, aircraft steels, vanadium-moly spring steels and as an underlayment or pad prior to applying hard facing alloys. Commonly used for joining stainless steels of unknown analysis and these steels to carbon steels. Also used for rebuilding shafts and blades used in the chemical, construction and mining industries and for broken stud removal.

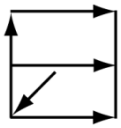
TECHNICAL DATA:

Typical Tensile Strength	As Welded: up to 120,000 psi (827 N/mm^2)
	Work Hardened: up to 180,000 psi (1241 N/mm^2)
Typical Yield Strength	Up to 90,000 psi (621 N/mm^2)
Elongation	Approx. 28%
Hardness	Approx. 300 HB
Polarity	AC or DC reverse (electrode +)

Diameter	Amperage
1/16” (1.6mm)	30-40
3/32” (2.4mm)	40-80
1/8” (3.2mm)	65-120
5/32” (4.0mm)	90-150
3/16” (5.0mm)	140-220

PROCEDURE:

Prepare joint area by removing foreign material. Bevel heavy sections to form a 90° vee. Preheat high carbon steels to 400°F (204°C). Use jigs, fixtures and tack welds to maintain alignment. Hold a short arc. Stringer beads are preferred to prevent overheating. Allow to cool before removing slag. Deposits will take a high polish when subjected to wear.



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