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CORTMMAIN 99 MC

DESCRIPTION

CORTMMAIN 99 MC is a metal-cored wire formulated to weld cast iron with minimal heat input, and therefore minimal dilution. This wire contains sufficient manganese to ensure porosity-free weld metal, and carbon to promote graphite.

APPLICATIONS

99 MC is used to weld cast iron alloys, including thin sections. Weld deposits are fully machinable.

PROCEDURE

Preheat and post heat according to base material. Machinability is improved when the part is preheated to 500°F.

WELDING PARAMETERS

Size	Volts	Amps	Stickout	Shielding Gas
.045"	19-21	120-150	0.5"	Ar-CO ₂ Mixtures
1/16"	20-22	160-220	0.5"	Ar-CO ₂ Mixtures

MECHANICAL PROPERTIES

Hardness: 180-200 BHN as welded
35+ Rc work hardened

CLASSIFICATION

None