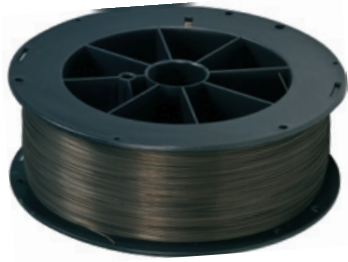


Technical Data Sheet

7109M-FC MIG Wire



Cronatron™
A LAWSON BRAND



Overview

This versatile, flux-cored wire alloy may be used for buildup and joining of manganese and carbon steels. Fast and easy to apply, it offers dense, tough deposits that work-harden in use. 7109M-FC MIG Wire may be built up to three heavy passes.

Features/Benefits

- Joins carbon and manganese steels
- Rapid work-hardening deposit
- Open-arc application
- Tough, high-tensile-strength weld deposit

Applications

- Hammer mills
- Railroad frogs
- Rock/stone crushers
- Liner plates
- Manganese wearplate
- Sleeves
- Rail points
- Switch points

Method of Application

DC reverse polarity

Identification

Labeled spool

Directions for Use

Remove any cracked or spalled metal. Use stringer or weave beads. Peen each pass. Unlimited build-up.

Technical Specifications

Tensile Strength: 124,000 PSI (855 MPa)
Yield Strength: 83,000 PSI (572 MPa)

Hardness (3rd Pass): Up to Rc 54
Gas: None or 75% Ar, 25% CO₂

Technical Tips

For typical operating parameters refer to Product Information Report PIRWE010.

