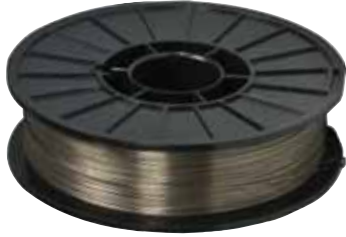


Technical Data Sheet

7770M-FC MIG Wire



Cronatron™
A LAWSON BRAND



Overview

A most versatile tubular, flux-cored wire alloy for joining and buildup of dissimilar steels, stainless steels and crack-sensitive steels. Precision alloying controls ferrite to resist cracking, yet allows rapid work-hardening with a minimum of deformation. Quick and easy application via the open arc method.

Features/Benefits

- Versatile and easy to use on all steels
- Excellent on crack-sensitive steels
- High tensile strength and elongation for joining dissimilar steels
- Rapid work-hardening in use
- Open arc application

Applications

- Butter layer for hardfacing
- Frogs and switch points
- Hammer faces

Method of Application

DC reverse polarity

Identification

Labeled wire spool

Directions for Use

Remove any cracked or spalled metal before welding. Use DC reverse polarity. No shielding gas required. Unlimited build-up. Remove slag after each pass. Weld with heavy stringer beads or weave beads.

Technical Specifications

Compressive Strength: 250,000 PSI (1,724 MPa)
Tensile Strength: 100,000 PSI (689 MPa)
Elongation: 35%
Hardness: Rc 45, Work hardened
Gas: None

Technical Tips

For typical operating parameters refer to Product Information Report – Typical Operating Parameters

