

## Covered Electrode for Direct Hardfacing on Cast Irons

# M H - 2 0 0 C

- Standard —
- Covering Low Hydrogen Type
- Tip Color Yellow

■ Application

Direct overlaying on various kinds of cast iron mold

■ Features

1. MH-200C is the covered electrode which makes direct hardfacing on the cast iron mold possible. The hardness of the deposited metal of MH-200C is lower than MH-100S and MH-100M.
2. The deposited metal is formed by austenite which has notch toughness. As the result, the deposited metal has excellent anti crack and anti blow hole property.
3. The hardness of the deposited metal is less than HRC30. The deposited metal is easy to work hardening because of austenite structure and is hardened by impact.

■ Welding Procedures

1. Preheating is not required but welding at proper preheating and interpass temperature, 100~150°C, is very efficient to prevent crack. Over preheating and too high interpass temperature rises the risk of crack because of increasing of penetration to the base metal.
2. Keep bead length between 80~120mm and do peening just after each bead is
3. Keep arc length as short as possible, weld by stringer bead and apply appropriate electric current. These prevent over dilution to the base metal.
4. The electrode should be re-dried for 30~60 minutes at over 300°C before use.

■ Typical Chemical Component of the Deposited Metal

C, Si, Mn, Cr, Ni, Special Elements

■ Typical Hardness of the Deposited Metal as welded

HV	HRC	HS
200~300	(11)~30	29~42

■ Appropriate Welding Current (AC or DCEP)

Diameter (mm)	2.6	3.2	4.0
Length (mm)	300	350	400
Current (A)	50~80	70~110	100~150
Min. Quantity (Kg)	3.0	5.0	5.0

Equivalent to wire for MAG welding: MH-200CS  
 Equivalent to electrode for TIG welding: MH-200CT