



MAGENTA

Typical Properties :

| | |
|-----------------------------|-------------------------------------|
| Undiluted Weld Metal | Maximum Value up to: |
| Tensile Strength | 71,000 PSI (490 N/mm ²) |
| Yield Strength | 60,000 PSI (415 N/mm ²) |
| Elongation | 25% |
| Conductivity | 14.3 |
| Density | 9.59/cm ³ |
| Hardness | Brinell 130 |

Flux Color: Pink

Recommended Torch Setting: Slightly Carburizing

Temperature Ranges:

| | |
|---------------------|---|
| Working Temperature | 1210°F (655°C) |
| Melting Range | 1140°F (620°C) Solidus 1200°F (650°C) Liquidus |

Deposition Rates:

| Diameter (mm) | Length (mm) | Weldmetal/ Rod | Joint length 1" (25mm) of rod |
|---------------|-------------|----------------|-------------------------------|
| 3/64 (1.2) | 18" (450) | .25oz (7.1g) | 17" (431mm) |
| 1/16 (1.6) | 18" (450) | .33oz (9.2g) | 24" (600mm) |

Welding Techniques: After cleaning metal, preheat generally to 350°F (200°C) then heat the joint area to 800°F (420°C). Melt off some flux and allow it to flow throughout the joint. Then add alloy.

Electrode Packaging & Dimensions:

| Diameter (mm) | 1/16 (1.6) | 3/64 (1.2) |
|---------------|------------|------------|
| Length (mm) | 18" (450) | 18" (450) |
| Rods/lb | 32 | 55 |
| Rods/kg | 70 | 121 |
| Feet/lb | 48 | 82.5 |
| Cm/kg | 3150 | 5445 |