

MIT MINERALS-TECH 545

MT-545

Impact Plus !! Joining & Buildup of Manganese Steel

Applications

- Rail Frogs
- Shovel Track
- Switch Points
- Mining
- Hammers
- Dissimilar Steels
- Roller Crushers
- Agricultural
- Idlers
- Drive Sprockets
- Drive Sprockets
- Marine
- Industrial

BENEFITS

Withstands impact and abrasion • All position welding
 Fast deposition rate • Super impact and thermal shock resistance
 Stable arc on AC as well as DC • Used as an underlay for 558 wire or stick

PROCEDURES

Prepare the repair area by first removing damaged metal.
 On heavier repair, bevel to a 90° Vee. Do not pre-heat.

Prevent excessive heat buildup.
 Maintain a close to medium arc and stringer beads. Backwhip to fill weld crater.
 Peen after each pass. On manganese repairs, keep as cool as possible.
 Put part in water if possible, leaving out the repair area only.

PROPERTIES

Hardness as weld	Up to 15-20 Rc
Hardness Workhardened	UP to 48 Rc
Tensile Strength	107,000 PSI



AVAILABLE SIZES & AMPERAGES

.035	.045	1/16	3/32	1/8	5/32	3/16	
—	—	—	—	95-140	120-190	140-260	ARC
—	Available	Available	—	—	—	—	MIG

MINERALS TECHNOLOGY® CORP
MINERALS-TECH® ALLOYS

Hard Facing must always be supported,
 MT-545 is the Stiffest material for this purpose.
 This product and it's development are dedicated to
 Harris F. Grether,
 my Dad, mentor and best friend
 on his 85th birthday 10-28-09