

Technical Data Sheet

7540M-FC MIG Wire



Cronatron™
A LAWSON BRAND



Overview

7540M-FC MIG Wire is a self-shielded, flux-cored wire that deposits a tough, low carbon martensitic structure. It has excellent resistance to metal-to-metal wear. This deposit's resistance to abrasion and impact makes it a versatile buildup alloy for carbon and low alloy steels. It is not recommended for joining.

Features/Benefits

- Magnetic
- Can be flame-cut
- Multiple pass deposits
- Abrasion and impact resistance
- Machinable

Applications

- Carbon steel frogs
- Carbon steel rolls
- Crane wheels
- Idlers
- Rail ends
- Steel shafts
- Switch points
- Track rollers

Method of Application

DC reverse polarity

Identification

Labeled wire spool

Directions for Use

Remove any cracked or spalled base metal before welding. Use DC reverse polarity. No shielding gas required. Hold a long arc using stringer or weave beads. Unlimited build-up. Remove slag after each pass and machine as required.

Technical Specifications

Hardness: Rc 36 to Rc 42
No. of Passes: Unlimited
Gas: None

Technical Tips

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

