MAGNA™ WELDING ALLOYS

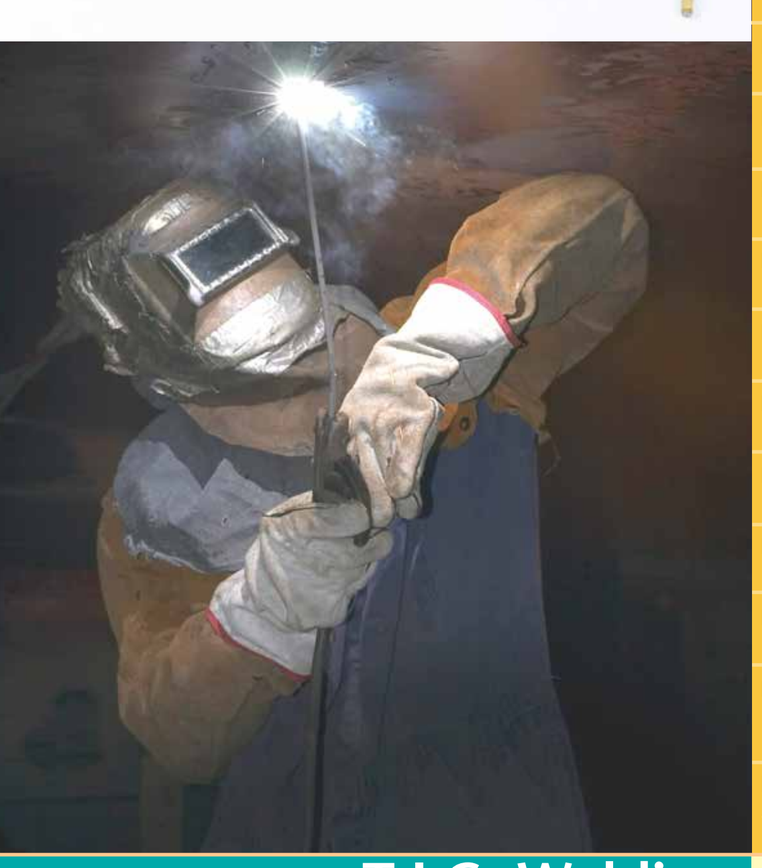
Your Partner for MRO Solutions

For Torch

	Description	Tensile strength up to p.s.i. (Kg/mm²)	Typical Hardness Brinell (B) or Rockwell C (RC)	Type of Flame
MAGNA 51	**Low-Temp Soldering Alloy for Dissimilar Metals.** Its extreme low-temperature application (179°C) provides outstanding versatility. Is ideal for all white metals, including zinc pewter and aluminum.	17000 (12.0)	15B	Reducing
MAGNA 55	**Superior Alloy for Aluminium.** Universal alloy right for all type of aluminum, Its unique two-stage melting range for both thin-flowing and build-up applications.	26000 (18.3)	45B	Reducing
MAGNA 66F	**Flux-Coated Silver Alloy for Maintenance** is a "All-Purpose" high silver content brazing rod that bonds well to almost all ferrous and non-ferrous metals.	67000 (47.1)	110 - 145B	Reducing
MAGNA 77F	**Super Strength Universal Flux-Coated Brazing Alloy.** A tough strong joining and build-up alloy for cast iron and other metals.. Deposits are totally machinable.	80000 ((56.3)	150 - 220B	Neutral To Oxidising
MAGNA 88C	**Low-Temp High-Strength Solder for Stainless Steel.** 500% stronger than ordinary solders and is ideal for food industry and refrigeration applications.	14000 (9.8)	13B	Reducing

For Arc

	Description	Tensile strength up to p.s.i. (Kg/mm²)	Typical Hardness Brinell (B) or Rockwell C (RC)	Current Setting
MAGNA 8N12	**Universal alloy for nickel alloys , cryogenic and dissimilar applications.** Resists high temperatures up to 1205°C and prevents cracking. Provides excellent corrosion resistance. Also suitable for Cryogenic and Dissimilar applications.	120000 (84)	140 - 215B	AC , DC - RP
MAGNA 100	**Superior Chamfering Electrode.** Chamfers, grooves & gouges practically all metals in seconds – without special equipment or skill.	NA	NA	AC , DC - SP
MAGNA 210	**Super-Versatile Electrode for Copper Alloys.** Joins wide variety of dissimilar metals & alloys. Reduces heat damage or the need for preheating.	65000 (45.7)	126 -140B	DC -RP
MAGNA 303 Gold	**Ferrite Balanced Super-Strength Non-Cracking Alloy for All Steels.** Welds dissimilar metal combinations and gives a deposit length that is 20-25% more than normal electrode.	128000 (90)	225B	AC , DC - RP
MAGNA 305	**Super-Tough Alloy for High-Strength Steels.** For welding T-1 and other heavy duty steels, construction steels and fabrication. Provides superior crack resistance – even without preheating.	115000 (81)	237B	AC , DC - RP
MAGNA 307	**"Magnamatic" Electrode for Mild Steel.** Provides extraordinary weldability for ease of use. Ideal for "on-site" and restrictive position use.	84000 (59)	178B	AC , DC - RP or SP
MAGNA 393	**Corrosion-Resistant Alloy for Stainless Steel.** A superior "vertical downhand" welding electrode with improved corrosion resistance and heat resistance properties.	86000 (60.5)	175B	AC , DC - RP
MAGNA 395	**Special Alloy for Duplex Stainless Steel.** Provides superb weld integrity to resists corrosion and cracks. Offers good resistance to saltwater corrosion.	110000 (77.3)	228B	AC , DC - RP
MAGNA 400	**Special Alloy for Crushing Equipment.** High alloy designed for crushers. Gives super impact and abrasion resistance.	NA	55RC	AC , DC - RP



MAGNA 401	**Universal Hardfacing Electrode.** Tough ferritic matrix that resists both impact and abrasion. Outwears other electrodes that cost twice as much.	NA	58 - 60RC	AC , DC - RP
MAGNA 402	**Impact-Resistant Alloy for Manganese Steel.** Withstand extreme shock, loading & impact. Ideal for heavy construction & mining equipment overlays and build-ups.	120000 (84.4)	As Welded = 187B Cold Worked = 473B	AC , DC - RP
MAGNA 403	**Hardfacing Electrode for High-Stress Abrasion.** Features a dense matrix impregnated with hard carbides to resist both high-stress and low-stress.	NA	55 - 60RC	AC , DC - RP
MAGNA 404	**Hardfacing Electrode for Extreme Abrasion.** Withstands even the most severe grinding abrasion. Outwear ordinary hardfacing rods as much as 30 to 1.	NA	67RC	AC , DC - RP
MAGNA 405	**Superior Build-Up Electrode.** Excellent for flame hardening. Non-cracking even on multipass deposits.	NA	25 - 30RC	AC , DC - RP
MAGNA 480	**Universal Tool Steel Electrode.** Welds practically all tool & die steels in hardened condition. Gives super hard & tough welds – without heat treatment.	NA	57 - 59RC	AC , DC - RP or SP
MAGNA 505	**"Super Ease" High-Strength Alloy for Aluminium.** Gives welds that are stronger than pure aluminium. Provides easy slag removal.	21500 (15.1)	40B	DC - RP
MAGNA 720	**Superior Alloy for Dirty or Burned Cast Iron.** Welds cast iron so greasy, rusty and burned that other electrodes will not even bond.	50000 (35.2)	Non Machinable	AC , DC - RP
MAGNA 770	**High-Strength Non-Cracking Machinable Electrode for Cast Iron.** Gives perfect machinable welds on practically all types of cast iron. Requires absolutely no preheating.	58500 (41.1)	160B	AC , DC - RP
MAGNA 777	**Generation II Machinable Electrode for Cast Iron.** Superior design enables economical use on virtually all types of cast iron. High-tech "controlled blast" pulse action automatically burns off surface contaminants before weld metal transfer.	66700 (46.9)	180B	AC , DC - RP
MAGNA ALLOY C	**Nickel-Based Electrode for Hastelloy Materials.** Provides outstanding hardness retention even at elevated temperatures. Outwears most hotwork tool steels – yet is entirely machinable.	98000 (68.9)	220B	AC , DC - RP

T.I.G. Welding

	Description	Tensile strength up to p.s.i. (Kg/mm²)	Typical Hardness Brinell (B) or Rockwell C (RC)	Current Setting
MAGNA 28 T.I.G.	**MAGNA 28** is a superior non-rusting TIG filler metal for rebuilding or overlaying metal against the most stressful wear and corrosion.	60000 (42.2)	130 -150B	AC TIG with HF
MAGNA 303 T.I.G.	**Super-Strength Non-Cracking Alloy for All Steels.**	120000 (84.4)	238B	DC - SP
MAGNA 309 T.I.G.	**Magna 309** is a special flux-cored TIG filler welding rod designed to weld Stainless Steel to Stainless Steel; Stainless Steel to Carbon Steel (ie. dissimilar steels) and to perform minor repairs on Cr-Mo pipes for achieving root run penetration without using inert gas like Argon in Petrochemical Plants, Refineries, and Power Plants.	79000 (55.5)	190B	DC - SP
MAGNA 480 T.I.G.	**Universal Tool Steel Filler.**	NA	57 - 59RC	DC - SP
MAGNA 506 T.I.G.	**"NextGen" Hi-Strength Aluminum TIG Filler Metal** is a versatile & welder-friendly aluminium TIG wire quality designed to offer high tensile and shear strength in as-welded condition and after post weld heat treatment.	35000 (24.6)	65B	AC
MAGNA 8N12 T.I.G.	**Universal Alloy for Nickel Alloys.**	120000 (84.4)	140 - 215B	DC - SP

Welding Aid Products

	Description	Tensile strength up to p.s.i. (Kg/mm²)	Typical Hardness Brinell (B) or Rockwell C (RC)	Current Setting
MAGNA 904	**"Heat-Ban"** Jelly-like compound that actually absorbs and dissipates heat. It is safe to use on all surfaces.	NA	NA	NA
MAGNA 940	**Instant Repair Compound** on surfaces and parts made of steel, copper, aluminum, cast iron, stainless steel, galvanized, brass and chrome.	8200 (5.77)	90 (Shore D)	NA

NA = Not Applicable

F - AFTER PRODUCT NUMBER SIGNIFIES 'FLUX COATED'.
C - AFTER PRODUCT NUMBER SIGNIFIES 'FLUX CORED'.

RP - SIGNIFIES 'REVERSE POLARITY'
SP - SIGNIFIES 'STRAIGHT POLARITY'

ISO 9001 : 2008
Certificate No.: CC 223

Visit our Web Site at:
www.magnagroup.com

To order MAGNA Welding Alloys phone or write to :

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MAGNA INDUSTRIAL CO. LIMITED
Total Quality Maintenance