

Technical Data Sheet

7500M-FC MIG Wire



Cronatron™
A LAWSON BRAND



Overview

Hardsurfacing alloy, tubular, flux-cored, small diameter wire formulated for buildup and surfacing where maximum abrasion resistance is needed. Fast, easy application in all positions with very little slag. Designed for use with CO₂, 7500M-FC provides deposits that are tough, non-porous, magnetic and exhibit excellent abrasion resistance.

Features/Benefits

- Very little slag
- All-position welding with small diameter
- Tough, non-porous deposits
- High resistance to impact and abrasion
- Rockwell hardness: Rc 55 to Rc 60
- Deposits can be flame-cut

Applications

- Dragline chains
- Rotary cams
- Shut liners
- Bucket teeth/shanks
- Bucket edges
- Clevis pins

Method of Application

DC reverse polarity

Identification

Labeled spool

Directions for Use

Remove all spalled or cracked metal before welding. See Product Information Report – Typical Operating Parameters for appropriate voltage, wire stickout and wire feed speed. Use stringer beads or a slight weave bead. Unlimited build-up.

Technical Specifications

Hardness: Rc 55 to Rc 60
Gas: 75% Ar, 25% CO₂ or 100% CO₂

Technical Tips

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

