

# Inweld MW 450

## Chemical Composition of Inweld MW 450

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
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Single values are maximum unless otherwise specified.

## Description and Applications

Inweld MW 450 is a high speed cutting electrode which leaves the surface ready to be welded. No air compressor or special equipment is needed. The special coating concentrates arc forces, and this easy re-strike electrode WILL NOT OVERHEAT. The slow burn-off rate gives more inches of cut per inch of electrode. Can be used on all ferrous and non-ferrous metals, except magnesium, removing bolts and rivets, piercing new bolt and rivet holes, trimming casting ears and tabs and preparing an edge for welding. Hold electrode at a steep angle to the plane of the work surface, 45-90 degrees. When arc is established, maintain a very short arc length, pushing electrode until penetration is complete. Hole or width of cut can be increased by using a slight weave or circular motion.

## Typical Weld Metal Properties

	<u>AWS Spec</u>
Average As-Welded Brinell Hardness:	170
Tensile Strength:	65,000 psi
Yield Strength:	40,000 psi
Elongation:	4%

## Recommended Parameters

SMAW

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
3/32"		30-70
1/8"		70-110
5/32"		90-130
3/16"		110-160

**INWELDCORPORATION.COM**

**Pennsylvania**  
3962 Portland Street  
Coplay, PA 18037

**North Carolina**  
1029 S. Marietta St.  
Gastonia, NC 28054

**Texas**  
9300 Lawndale St.  
Houston, TX 77012

**California**  
6201 Coliseum Way, Unit A  
Oakland, CA 94621