

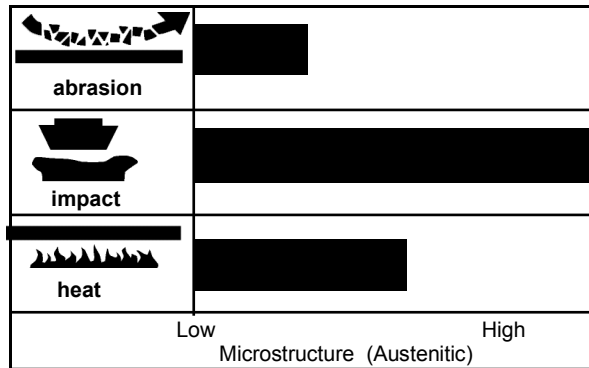
## DESCRIPTION:

A special stainless alloy electrode balanced for maximum strength and crack resistance, **McKay GP** is recommended for joining dissimilar metals and hard-to-weld steels. Deposits have over 20% ferrite and crack resistance equal to armor welding electrodes. McKay GP can be used for any high strength application, where wear, impact, heat and corrosion resistant properties are required. Excellent for high alloyed steels and for repair of cracked dies.

## OPERATIONAL CHARACTERISTICS:

McKay GP has excellent operation in all positions. It also has very good heat and corrosion resistance.

## RELATIVE WEAR RESISTANCE:



## TYPICAL WELD METAL PROPERTIES\* (CHEM PAD):

### Weld Metal Analysis

Carbon (C)	0.06
Manganese (Mn)	1.00
Silicon (Si)	0.50
Chromium (Cr)	26.50
Nickel (Ni)	9.00
Iron (Fe)	Bal.

## TYPICAL MECHANICAL PROPERTIES\* (AS WELDED):

Tensile Strength	120,000 psi (828 MPa)
Yield Strength	90,000 psi (621 MPa)
Elongation % in 2"	27%
Thickness	As required
Machinability	Good
Cannot be flame cut	
Non-magnetic	

\*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers Company expressly disclaims any liability incurred from any reliance thereon. No data is to be construed as a recommendation for any welding condition or technique not controlled by Hobart Brothers Company.

# Hobart GP

## RECOMMENDED OPERATING PARAMETERS:

Diameter		Type of Power	Optimum Amps
Inches	mm		
3/32	2.4	DCEP* or AC	70
1/8	3.2	DCEP* or AC	105
5/32	4.0	DCEP* or AC	140

\*Preferred

## AVAILABLE DIAMETERS AND PACKAGES:

Diameter		Length		5-lb. Can	5-lb. Tube
Inches	mm	Inches	mm		
3/32	2.4	10	254	S582130-032	--
1/8	3.2	14	355	--	S582144-045
5/32	4.0	14	355	--	S582151-045

## APPLICATIONS:

- Welding Attachments to Manganese Castings
- Welding T-1 Steel Lips to Manganese Buckets
- Welding Grouser Bars to Grousers

**TECHNICAL QUESTIONS?** For technical support of Hobart Filler Metals products, contact the Applications Engineering department by phone toll-free at 1-800-532-2618 or by e-mail at [Applications.Engineering@hobartbrothers.com](mailto:Applications.Engineering@hobartbrothers.com)

### CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 St, # 130, Doral, FL 33166-6672 (can also be downloaded online at [www.aws.org](http://www.aws.org)); OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

Material Safety Data Sheets on any Hobart Brothers Company product may be obtained from Hobart Customer Service or at [www.hobartbrothers.com](http://www.hobartbrothers.com).

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Revision Date: 140829 (Replaces 070404)  
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