SME G13

AUSTENITIC MANGANESE STEEL ELECTRODE FOR HIGH IMPACT RESISTANCE

Alloy Basis

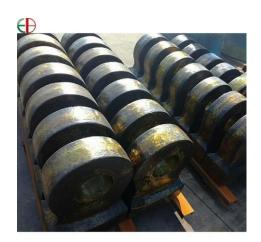
Mn, Ni, Cr,

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Characteristics:

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Excellent abrasion resistance in the work-hardened condition. Enhances component life against impact and abrasion simultaneously. The deposit is work- hardening and highly resistant to cracking and deformation during working.



Typical Application

Recommended for crushing equipment parts like rocks, jaws, cones, gyratory crushing mantles, excavator teeth, manganese rails, hammers, buckets, etc. Used For joining manganese steel/ Hadfield steel parts and hard facing of parts subject to heavy impact and stress.

Mechanical Properties

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Hardness:

As welded 15 - 22 HRC

Work Hardening 40-48 HRC

Welding Current : AC, DCEP

Size (Ø mm)	3.15	4.00	5.00
Current (amps)	90 - 120	120 - 160	170 - 210

Availability:

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Standard Size: 5.0, 4.0, 3.15 in 350 mm length

Packing: 2 kg.

Procedure

Clean the weld metal surface, Remove the fatigue material by gouging with SME I00. Do not preheat Manganese Steel. Temperature should be kept below 150 °C using staggered or skip welding techniques. Small components can be immersed in water for controlling the temperature