

HIGH DEPOSITION MANGANESE STEEL ELECTRODE

Alloy Basis

Mn, Cr

Characteristics :

Electrodes have very fast work hardening tendency, high abrasion resistance and resistance to deformation and cracking. Work hardening type electrode with very high deposition rate. Extremely ductile and hence ideal for intricate and hardened manganese steel parts..



Typical Application

Used for all position welding of 14% Mn steels, armour steels, carbon steels, Hadfield Steel. Ideal as buffer layers before surfacing on 14% Mn steels, hard or unknown steels. For joining manganese steel parts, hard facing parts are subject to heavy impact and stress. Very thick build-ups possible without cracking. Specially developed for the mining industry.

Mechanical Properties

Hardness :

As welded 15 - 22 HRC

Work hardening 40-50 HRC

Welding Current : AC, DCEP

Size (Ø mm)	3.15	4.00	5.00
Current (amps)	100 - 130	130 - 170	160 - 200

Availability:

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 using 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 to control the temperature.