

Applications

Rock crushing jaws & crusher mantles. Manganese steel rail points and crossings Dredger bucket teeth & cement grinder teeth Bulldozer teeth, manganese steel casting etc.

Characteristics on Usage

This is a medium heavy coated low hydrogen electrode for hard facing applications on austenitic manganese steel parts. the weld metal is tough and the work hardens to more than 500 BHN in service under severe impact. The weld deposit consists of 12% Mn composition, when used on mild steel or low alloy steel parts it gives a buffer layer of stainless steel.

Notes On Usage

➤ 1) Dry the electrodes at 350-400°C for 60 minute before use

Welding Positions

1G 2F

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Mo %
0.50 – 1.00	12.0 – 16.0	1.30 Max	0.030 Max	0.030 Max	0.50 – 1.50

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
3.15 x 450	5	20	AC / DC (+)	100 – 140
4.00 x 450	5	20		140 – 180
5.00 x 450	5	20		180 – 220

HARDNESS : A. W. : 200 BHN W.H. : 500 BHN