



NEXA-1080

HIGH RESISTANCE TO IMPACT AND DEFORMATION SUPERIOR CUSHIONING WELDING ALLOY

ALLOY BASE : Fe, Cr, Ni, Mn

SPECIAL FEATURES

- High work hardening in service.
- Highly crack resistance.
- Excellent all position welding.
- Superior resistance to impact deformation, heat and mild corrosion.

RECOMMENDATIONS

A versatile welding alloy for austenitic manganese steel and joining of mild steel and difficult steel. Very well suitable for cushioning layer under hard facing deposits. The weld metal gives good hardness in as deposited and work hardened under repeated and pounding load in service. Easy slag detachability.

APPLICATIONS

Sprockets, track pads, excavators, shovel and dragline buckets and other earth moving equipment, crusher roller, buildup of hammer, mantles, Dozer blades.

PROCEDURES

Clean weld area, fatigued material should be remove by chamfering. No preheating is required for manganese steel. Always use skip or staggered welding. Maintain a short to medium arc.

TECHNICAL DATA

Tensile Strength : 55-65 kgf / mm²
Elongation : 30-40 %

CURRENT RANGE : DC (+)

SIZE mm	2.50	3.15	4.00
CURRENT (Amps)	50-80	80-100	110-150