



# NEXA-7078

## ELECTRODE FOR AUSTENITIC MANGANESE STEELS.

**ALLOY BASE :** Fe, Cr, Ni, Mn

### SPECIAL FEATURES

- Specially formulated low heat input austenitic. Stainless- steel electrode.
- Has excellent heat resistance up to 900°C and is resistant to corrosion by atmosphere, sea water, weak acid etc.

### RECOMMENDATIONS

Use dry electrodes at the lowest possible current. While reconditioning of the worn out parts, the hardened layer should be ground out. Peening is a must. Total weld deposit should be less than 25 mm thick.

### APPLICATIONS

For joining austenitic manganese steels. Ideal for joining austenitic manganese steels to mild steels, difficult steel, high alloy steels etc. Surfacing manganese steel rails. Repairing crack in austenitic manganese steel casting.

### PROCEDURES

Use short arc and adjust low amperage, especially for high manganese steel. Peen and deslag each pass.

### TECHNICAL DATA

Tensile Strength : 59-64 kgf / mm<sup>2</sup>  
Elongation : 30-40%

### CURRENT RANGE (AC/DC+)

SIZE mm	3.15	4.00
CURRENT (Amps)	80-110	110-140