



# NEXA-7079

## HIGH DEPOSITION MANGANESE STEEL ELECTRODE.

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

### SPECIAL FEATURES

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

### RECOMMENDATIONS

Re-dry the electrodes at 200°C for one hour. Use low current and short arc. Avoid preheat/ overheat in case of manganese steels.

### APPLICATIONS

For all position welding of 14% Mn steels, armour steels, carbon steels. Also for surfacing of such steels. Ideal as under layers before surfacing on 14% Mn steels. Very thick build-up possible without cracking.

### PROCEDURES

Ensure proper cleaning of the area to be welded .do not preheat manganese steel. interpass temperature should be kept below 150°C using staggered or skip welding. Hot peening helps reducing stresses. Cool slowly. For small components, immerse in water.

### TECHNICAL DATA

Tensile Strength	:	80-85 kgf / mm <sup>2</sup>
Elongation	:	30-33%
Hardness	:	42-50 HRc

### CURRENT RANGE (AC/DC+)

SIZE mm	3.15	4.00	5.00
CURRENT (Amps)	100-140	150-190	180-220