



NEXA-7074

SPECIAL AUSTENITIC MANGANESE STEEL ELECTRODE

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

SPECIAL FEATURES

- The deposit is work- hardening type and highly resistant to cracking and deformation during working.
- Excellent abrasion resistance in the work- hardened condition.
- Prolonged working life even when subjected simultaneously to impact and abrasion.

RECOMMENDATIONS

Clean weld area. Maintain short arc length. Maintain interpass temperature below 150°C by skip welding. Hot peening is advisable to relieve stresses.

APPLICATIONS

For joining manganese steel parts, hard facing of parts subject to heavy impact and stress. For use on big crushing equipment for rocks, jaws, cones, gyratory crushing and manganese rails etc.

PROCEDURES

Ensure proper cleaning of area to be welded. Removes the fatigued area by gouging. Do not preheat manganese steel. Interpass temperature should be kept below 150°C using staggered. Hot peening helps reducing stresses. Cool slowly. For small components, immerse in water.

TECHNICAL DATA

Hardness : 40-45 HRc

CURRENT RANGE (AC/DC+)

SIZE mm	3.15	4.00	5.00
CURRENT (Amps)	70-120	130-190	170-250