

Hardfacing and Wear Resistant SMAW Electrode

HARDMANG 1

Product Features:

- Work hardening type covered electrode for austenite manganese steel.
- High toughness weld metal to get fast hardening on high impact working condition.
- Suitable for buildup and repair welding of Mn steel.
- Welding of austenite Mn steel to Mn steel.

Applications:

- Suitable for repair welding of coned mining crusher, hammering crusher, impactor bars, rail frogs and crossings.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Cr	Fe
0.79	0.58	14.2	2.9	Bal.

Typical hardness of weld metal

As welded HRC	After work hardening HRC
23	47

Size (mm) & recommended welding parameters (A)

Diameter / Length	2.6/300	3.2/350	4.0/350	4.8/350
Flat position	50~80	110~140 (DC+110~130)	150~180 (DC+150~170)	180~230

Note:

- 300~350°C x 1 hr baking prior to use.
- Inter pass temperature $\leq 260^{\circ}\text{C}$ while multiple passes welding to avoid crack, not necessary for preheat and post heat.