



SUPER-Mn

CHARACTERISTICS AND APPLICATIONS :

Super-Mn is an electrode depositing high manganese steel weld metal. The weld metal possesses excellent toughness and work hardens under impact. The deposit exhibits an austenitic structure and is ideally suited for re-surfacing austenitic manganese steel components like crusher jaws, hammers, etc. for resistance against wear by impact and abrasion.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	Cr
Percent	: 0.85	15.5	0.55	2.5

WELD METAL HARDNESS:

As welded (on mild steel-two layers): 200-250 BHN

Work hardens (under impact) to 500 BHN

CURRENT AND PACKING DATA: AC / DC(+)

Size (mm)	: 6.3X450	5x450	4x450	3.15X450
Dia x Length				
Current Range (Amps)	: 200-270	160-200	130-160	90-120
Qty.(Pcs./Carton)	: 20	35	50	75

PRECAUTIONS:

1. Ensure the surface to be built-up is free of all contaminants.
2. Remove by grinding any work hardened zone. A magnet can detach a work hardened zone.
3. Ensure the electrodes are dry. Re-dry the electrodes at 200-250°C for one hour.
4. When welding on austenitic manganese steels, restrict heat input by:
 - a) Short arc;
 - b) Stringer bead;
 - c) Deposits of short lengths and thickness;
 - d) Intermittent welding;
 - e) Keeping base material partly immersed in water.