

SUPRAMANGAN Cr

TOP FEATURES

- Basic coated austenitic manganese steel MMA electrode for wear resisting hard facing deposits and for joining.
- Used for hardfacing or buttering on carbon steels and high Mn steels, the deposit is only machinable by grinding.
- The weld metal will increase in hardness by cold-working, from ~200-250 HB to ~400-500 HB, therefore it is particularly suitable for components which are subjected mainly to wear, caused by heavy impact and shock.
- When building up several layers, it is recommended that a buffer layer is deposited with 307 type MMA electrode.
- Flat welding position only.
- Shall be used in DC+ current.

TYPICAL APPLICATIONS

- Hardfacing/ reconditioning of wear resisting components such as crusher jaw plates, crusher cones, pulverising hammers and beating arms

CLASSIFICATION

EN 14700 E Z (Fe9)

CURRENT TYPE

DC+

WELDING POSITIONS

Flat/Horizontal

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Cr
0.65	16	12.8

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Hardness (HRc)
Typical values	As welded	23
	After hammer-harden	52

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
4.0 x 450	180-200
5.0 x 450	220-260

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
5.0 x 450	CBOX	41	5.6	W000380869

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.