



Hard Facing (Iron Base)

Welding Electrode (AC-DC)

FEATURES:

A multipurpose wear facing ferrous base, nickel manganese alloy used for heavy impact and long wearing applications. Weld deposits rapidly work harden from the as-welded hardness of Rockwell C 35-38 to Rockwell C 47-50 during operation. Welds are crack resistant, dense, porous, and easily cut with an oxyacetylene torch.

APPLICATIONS:

Used for repair on manganese type steels and for wear facing low and medium alloy steels that require impact resistance. Ideal for railroad construction equipment and mining operations. Examples include: railroad tracks, frogs, switches, rock crusher rolls and mantles, hammers for mills, quarry and stone crushing and fragmentizing operations.

TECHNICAL DATA:

| | | | |
|-------------------------------|---|---------|---------|
| Alloy Type | Special work hardening nickel-manganese | | |
| Hardness | Rockwell C 35-38, as welded | | |
| | Rockwell C 47-50, work hardening | | |
| Tensile Strength | 125,000 psi | | |
| Machinability | Must be ground | | |
| Electrode Diameter: | | | |
| inches | 1/8 | 5/32 | 3/16 |
| mm | 3.2 | 4.0 | 4.8 |
| Approximate AMP Setting | 85-125 | 110-140 | 130-170 |

PROCEDURE:

Use AC or DC, reverse polarity. Clean area to be welded. Do not preheat. Employ low side of amperage setting to minimize heat input. Maintain a short arc gap and peen after depositing about four inches of a slightly weaving bead. Use the skip welding technique to distribute heat input evenly. Cool slowly to prevailing temperature.

Manufactured by **AmAlloy Industries***
To Order - Call: **507-373-1677** or **800-735-3040**
or E-mail: amalloyindustries@gmail.com
www.amalloy.com