

TECHNICAL DATA SHEET

BRAND NAME: MANGALAM MANGAN

IS: 276-2000 Grade 2

DESCRIPTION AND APPLICATIONS:

This is medium heavy coated electrode for hard facing application on austenitic manganese steel Parts . The weld metal is tough and work hardness to more than 500 BHN in service under severe impact. The weld deposits consists of minimum 12% Mn composition, when used on mild steel parts.

Typical applications:

- Rock crushing Jaws & Crusher Mantel
- Manganese Steel rail Points and Crossing
- Dredger Bucket Teeth & Cement Grinder teeth
- bulldozer Teeth
- Manganese Steel Casting etc.

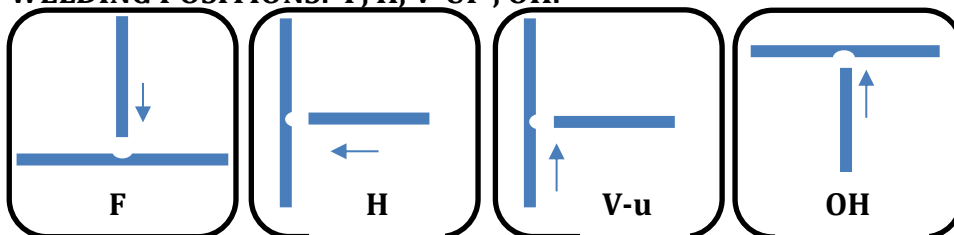
CHEMICAL COMPOSITION OF WELD METAL (%)::

Elements	C	Mn	Si	S	P
%	0.90-1.05	11.50 – 14.00	1.00 Max	0.025 Max	0.080 Max

MECHANICAL PROPERTIES:

Hardness	230 – 250 BHN
After work Hardening	500 – 550 BHN

WELDING POSITIONS: F, H, V-UP , OH.



CURRENT CONDITION: DC (+/-)

PACKING DATA:

Size SWG	SIZE mm	No of electrodes /Packet	No of electrodes /Cartoon	Current in Amps
10	3.15 X 350/450	105	420	100 - 140
8	4.00 X 350/450	65	260	140 - 190
6	5.00 X 450	40	160	180 - 220