



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.

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