

# PRODUCT DATA SHEET

## Afrox CrMn

Afrox CrMn is a rutile coated electrode designed for joining and surfacing 11-14% manganese steels. The deposited weld metal will work harden under impact load to a hardness of 480-590 HV. The electrode is recommended for use in the downhand position only.

### Applications

Afrox CrMn can be used to reclaim worn austenitic manganese parts or as a buffer layer on other grades of steels prior to hardfacing. The deposit is extremely crack resistant and will rapidly work harden, making it ideally suited for welding on railway crossings, dredger buckets, crusher jaws, loader buckets and other ground engaging equipment.

### Classifications

DIN	8555	E8-UM-200/55-KP
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### Typical Chemical Analysis (All weld metal)

% Carbon	0,5 - 0,9	% Silicon	0,1 - 0,5
% Manganese	15,0 - 18,0	% Chromium	12,0 - 15,0

### Typical Hardness

As Deposited	22 HRc
Work Hardened	48 - 55 HRc

### Packing Data

(AC DC+ 70 OCV min)

Diameter (mm)	Electrode Length (mm)	Current (A)	Pack Mass (kg)	Item Number
4,0	350	130 - 170	4,0	W075628
5,0	350	170 - 220	4,0	W075629

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