

PRODUCT DATA SHEET

Afrox NiMn

Afrox NiMn is a basic coated electrode designed to provide a non-magnetic austenitic 11-14% manganese deposit for service involving high impact. The deposits are extremely tough, non-porous, crack-free and work hardened readily under impact loading to approximately 440-600 HV (45-55 HRc). The electrode is recommended for downhand welding only.

Applications

Although primarily intended for reclaiming worn parts made from 11-14% manganese steel (Hadfield manganese steel), Aprox NiMn can also be used for joining this material or hardfacing carbon steel components subject to severe impact loads. Under these conditions, an austenitic stainless steel buffer layer should be applied. This electrode can be used on cast manganese steel railway crossings, dredger buckets, crusher jaws, swing hammers, blow bars and grizzlies.

Classifications

DIN	8555	E6-UM-55-GS
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Typical Chemical Analysis (All weld metal)

% Carbon	0,5 - 0,9	% Nickel	2,75 - 6,0
% Manganese	11,0 - 16,0	% Chromium	0,5 max
% Silicon	1,3 max		

Typical Hardness

As Deposited	24 HRc
Work Hardened	45 - 55 HRc

Packing Data

(DC+ 70 OCV min)

Diameter (mm)	Electrode Length (mm)	Current (A)	Pack Mass (kg)	Item Number
4,0	350	130 - 170	4,0	W075664
5,0	450	170 - 220	6,0	W075665

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