

MACROMANG

OPEN-ARC FLUX-CORED REBUILDING WIRE

CHARACTERISTICS:

- austenitic chrome - nickel - manganese steel;
- extremely **tough** and **impact resistant**;
- work hardens under load and can be multi-layered;
- often **diminishes** and/or **eliminates** the necessity of **hardfacing**;
- used to **build up and join** 11-14% manganese steel, carbon steel and other alloy steels;
- deposit is machinable before work hardening;
- very good resistance to deformation;
- excellent underbase for abrasion resistant hardfacing such as HA-4 series, HA-5, and so on;
- **excellent slag removal** revealing a smooth bead of austenitic chrome-nickel-manganese steel;
- transfer is semi-globular/semi-spray and **very smooth** to apply.

MECHANICAL PROPERTIES:

- 18 - 24 RC as deposited
- 45 - 55 RC work hardened

PROCEDURE:

- DC reversed polarity, 28-32 Volts, 275-375 Amps.
- remove all damaged material;
- avoid localised overheating of manganese steel by keeping bulk of part below 550°F;
- avoid thermal shock;
- stick-out: 2 - 3"

TYPICAL APPLICATIONS:

- crusher parts, wobblers, runners, impellers, wheel excavator teeth, crusher jaws, muller tires, etc.

OTHER:

- Deposition Rate: 10 - 20 lbs./hr.;
- available in diameters of 7/64", 3/32";
- packaging: 28 spools, 55 lb. coils, 100, 250 & 450 lb. pay-off-packs.