


Technical data sheet <small>011121MBA</small>	Coated SMAW Electrode WA HARDFACE NM14-E	 Welding Alloys
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CLASSIFICATION

EN 14700: E Fe9

DESCRIPTION

- Rutile-basic coated electrode for hardfacing
- Deposits a "Hadfield" manganese steel type alloy.
- Designed for rebuilding 14% manganese steel parts.

APPLICATIONS

Building up of 14 % manganese or C-steel parts subjected to heavy shocks or crushing tools
 Sub-layer on 14 % manganese steels before hardfacing.

Austenitic manganese steels must be kept cool during welding. Do not preheat. Use intermittent or staggered weld runs and ensure interpass temperature is kept as low as possible. Deposit can be multi-layered.

Examples

Reclaiming crusher jaws and rolls, gyratory mantles, blow bars, swing hammers, manganese dredge components such as buckets and tumblers, railroad sections, bucket teeth and lips, dragline manganese steel shackles and repair of defects in manganese steel castings

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Cr	Ni	Fe
0.9	13.0	0.3	2.0	2.0	Bal.

Structure: austenite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit:

As welded: 200 - 240 HB

Work hardened: 40 - 50 HRc

OPERATING CONDITIONS

Electrode Ø x L [mm]	3.2 x 350	4.0 x 450	5.0 x 450
Current [A]	100 - 140	140 - 180	180 - 230
= +, -	~ 65V		

WELDING POSITIONS

EN ISO 6947: PA, PB, PC

ASME IX: 1G, 2F, 2G

PACKAGING

Electrode Ø x L [mm]	3.2 x 350	4.0 x 450	5.0 x 450
Weight/box [kg]	5	6.5	6.5

Other packaging and other sizes: please consult us