



MODI-Mn HARD SURFACING ELECTRODE

CHARACTERISTICS : An electrode with basic type of coating, suitable for reconditioning of austenitic manganese steel parts. Adequate penetration and smooth transfer of alloying elements to weld pool ensures uniform weld metal. Slag is easily removable and leaves clean weld.

APPLICATIONS :

- * Crusher jaws
- * Grinding hammers
- * Railway crossings
- * Frogs
- * Dragline bucket teeth
- * Ball mills
- * Austenitic manganese steel crossings

RECOMMENDATIONS : Use dried electrodes at the lowest possible current. While reconditioning of the worn out parts, the hardened layer should be ground out. Do not allow the job to be over heated. Cool the job continuously with water flow etc. Peening is a must. Total weld deposit should be less than 25 mm thick. If necessary, use buffer layer with Modi SS-Mn electrode.

CHEMICAL ANALYSIS OF WELD-METAL (%) :

	C	Mn	Si
	1.0 max	12.0-14.0	0.8 max

HARDNESS :

170-220 BHN (on two layers) in as welded condition.
400-500 BHN after work hardening.

CURRENT CONDITIONS : USE AC OR DC (+)

Size (mm)	2.5x350	3.15x350 3.15x450	4.0x450	5.0x450	6.3x450
Amps	70-90	80-110	120-160	170-200	210-240



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