



# MODI XL Mn

## HARD FACING 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 bead.

**APPLICATIONS** :

- Crusher Jaws
- Railways Crossing
- Dragline Bucket Teeth
- Ball Mills
- Grinding Hammers
- Frogs
- Austenitic Manganese
- Steel Crossing

**RECOMMENDATIONS** : Use dry 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 XL SS Mn electrode.

**CHEMICAL ANALYSIS OF WELD METAL (%)** :

C	Mn	Si
1.0	12-14	0.8
max	max	max

**HARDNESS** :

ON TWO LAYER DEPOSIT

WELD HARDNESS : 170-220 BHN

WORK HARDNESS : 400-500 BHN

**CURRENT CONDITIONS : USE AC OR DC (+)**

Size (mm)	2.5 x 350	3.15 x 350 3.15 x 450	4.0 X 350	5.0 X 350
Range (Amps.)	70-90	80-110	120-160	170-200



## WELD EXCEL INDIA LTD.

D-230, Phase VII, Focal Point,  
Ludhiana - 141 010

Phone : (0161) 3259335 Telefax : 0161-2677459

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MODI ARC ELECTRODES CO.  
(A UNIT OF MODI INDUSTRIES LTD.)  
MODINAGAR (U.P.) 201 204