

RATNA HFMN

Basic coated Electrode depositing 12 % manganese weld Metal.

CLASSIFICATION : DIN-8555: E7 –UM-250KP

APPROVAL :

CHARACTERISTICS : A hydrogen controlled, medium heavy coated hardfacing electrode, for welding austenitic manganese steel components having 12% Mn and has work hardening properties under severe impact.

APPLICATION :

- 1) Suitable for stone crushing jaws.
- 2) Buckets, excavator teeths, Mn steel rails.
- 3) Austenitic manganese steel castings, hammers, crusher mantle etc.
- 4) Cement grinder rings, Rail crossovers, Rail frogs and switches etc.

RE-DRY CONDITION : Re-Dry the electrode at 250°C-300°C for 1 hour.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P
0.80 max	12.0-14.0	0.80 max	0.030	0.030

WELD METAL HARDNESS:

Hardness (As weld)	Work Hardness
200-250 BHN	500-540 BHN

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+/ AC) Amps	No. of Pcs./pkt.	No. of Pcs./Case
3.15/ 3.20 X 450	1/ 8" X 18"	90-120	110	440
4.00 X 450	5/ 32" X 18"	130-160	65	260
5.00 X 450	3/ 16" X 18"	160-200	45	180

Customer packing on request.