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selectarc FC 14 Mn DC+

BUILD-UP

DESCRIPTION

Open arc build-up wire. Work-hardening austenitic manganese flux-cored wire alloyed with chromium and nickel for improved weld deposit properties over standard manganese alloys. It is designed for build-up and fabricating of manganese steel or carbon steels and low alloy steels. **Deposits are very tough, and work-hardens rapidly in-service** as plastic deformation occurs during impact. **Deposit can be flame cut.**

TOTAL ALLOY CONTENT: 20 % (Carbon, Silicon, Manganese, Chromium, Nickel)

TYPICAL APPLICATIONS

Build-up of crusher jaws, cones and roll shells, gyratory crusher mantels, hammer mill and impact breaker bars, railroad track components. Joining of manganese steel components.

PROCEDURE

When welding out-of-position it is best to use a shielding gas of 100% CO_2 at 40-45 cfh and DC Straight Polarity. Parameters: **.045''**- 23 volts, 270 ipm, 3/4" stick-out **1/16''** - 21 to 22 volts, 200 ipm, 3/4" stick-out.

MECHANICAL PROPERTIES

Hardness (as-welded):	20 - 22 HRC	Work hardening: 50 - 55 HRC
Deposit thickness:	Unlimited	

WELDING PARAMETERS

Diameter:	1/16" (1.6 mm)	.045" (1.2 mm)
Voltage:	23 - 28 V	19 - 27 V
Amperage:	150 - 300 A	100 - 200 A
Stick out:	1″ - 1 1/2″	3/4″ - 1 1/4″
Packaging:	Spool of 11,4 kg	

Other diameters available on request.

Electrodes also available: **Selectarc HB 14 Mn**

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Specialized welding alloys and technology. For technical assistance or for ordering:

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