

Inweld Ni-Cro-Mang

Chemical Composition of Inweld Ni-Cro-Mang

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
Balance	0.7	4.5	4.0	---	13.0	---	---	---	---	---

Single values are maximum unless otherwise specified.

Description and Applications

For welding, joining, and overlay of Manganese to Manganese, or Manganese to dissimilar alloy steels including Mild or High Carbon Steel. High Manganese content combined with Nickel and Chromium produces a work-hardening weld deposit with excellent crack resistance against extreme impact, compression, and shock. The "Armoring" characteristics of this electrode make it particularly suitable for quarry and mining equipment including dredger bolts, excavator pins, dredger bucket teeth, mill hammers, crusher jaws, railroad and earth moving equipment. Weld deposits are non-magnetic, fully austenitic and easy to flame cut using an acetylene torch. Machining is possible using tungsten carbide tools.

Typical Weld Metal Properties

	<u>AWS Spec</u>
Average As-Welded Brinell Hardness:	170-220
Tensile Strength:	125,000 psi
Yield Strength:	
Elongation:	

Recommended Parameters

SMAW

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
3/32"		80-100
1/8"		100-140
5/32"		140-180
3/16"		170-220
1/4"		210-280

INWELDCORPORATION.COM

Pennsylvania
3962 Portland Street
Coplay, PA 18037

North Carolina
1029 S. Marietta St.
Gastonia, NC 28054

Texas
9300 Lawndale St.
Houston, TX 77012

California
6201 Coliseum Way, Unit A
Oakland, CA 94621