

DESCRIPTION

Foundry Co-Mang is a manganese steel coated electrode. It is suitable for multi-layer build-up and has excellent work hardening characteristics. It is usable for austenitic manganese steel repair, build-up, and joining.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Low
Impact Resistance	Very High
Deposit Layers	Multiple
Tensile Strength	128,000 psi
Yield Strength	71,000 psi
Elongation	42%
Hardness, As Deposited	170 – 210 BHN
Hardness, Work Hardened	350 – 450 BHN
Non-Magnetic	
Austenitic	

ALLOY TYPE

Austenitic Manganese Steel

TYPICAL APPLICATIONS

Typical applications include:

- Rock Crushing and Mining
- Crusher Rolls, Jaws, Grizzly Bars, Screens, Grates, Impactor Bars
- Dredge Pump Parts
- Hammer Mill Hammers
- Shovel Pads
- Latch Pins
- Dipper Front Edge and Teeth

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	5/32 (4.0)	3/16 (4.8)
Current, Amp. DCRP	140 – 180	175 – 225
Position	Flat	Flat

Diameter, In. (mm)	¼ (6.4)
Current, Amp. DCRP	220 – 280
Position	Flat

STANDARD SIZES & PACKAGING

<u>Diameter</u>	<u>Packaging</u>	<u>Part #</u>
5/32" (4.0mm)	10# Box	11814000
5/32" (4.0mm)	60# Bulk Pak	44441050
3/16" (4.8mm)	10# Box	11814100
3/16" (4.8mm)	60# Bulk Pak	44441250
¼ " (6.4mm)	60# Bulk Pak	44441650

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NOTICE - Failure to follow manufacturer's directions for use may result in equipment or material failure and void any applicable warranty. The data provided or referenced herein is provided for informational purposes only, without guarantee or warranty and represents "typical" results when Stoody products are used in accordance with internal Stoody procedures. Other tests and procedures may produce differing results. Stoody expressly disclaims any liability resulting from reliance on this data.
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