

Ratna HF MN

CLASSIFICATION

- DIN-8555 E7 -UM-250KP

APPLICATIONS

- Suitable for stone crushing jaws.
- Buckets, excavator teeth, Mn steel rails.
- Austenitic manganese steel castings, hammers, crusher mantle etc.
- Cement grinder rings, rail crossovers, rail frogs and switches etc.

DESCRIPTION

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

TYPICAL WELD METAL CHEMICAL PROPERTIES (ELEMENT %)				
CARBON (C)	MAGNESIUM (MN)	SILICON (SI)	SULFUR (S)	PHOSPHORUS (P)
0.80 MAX	12.0-14.0	0.80 MAX	0.030	0.030

CURRENT POLARITY	WELDING POSITION
DC(+), AC	FLAT, HORIZONTAL, VERTICAL, OVERHEAD

TYPICAL WELD METAL MECHANICAL PROPERTIES (ELEMENT %)	
HARDNESS BHN (AS WELD)	WORKING HARDNESS BHN
200-250 BHN	500-540 BHN

SIZE AND CURRENT RECOMMENDATIONS		
SIZE D X L (MM)	SIZE D X L (IN)	CURRENT (AMPS) DC+, AC
3.2mm x 350mm	1/8" x 14"	90-120
4.0mm x 350mm	5/32" x 14"	130-160

RE-DRY CONDITIONS

- Re-dry the electrode at 250°C-300°C for 1 hour.

NOTE:
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