

Classifications

DIN 8555	EN 14700
E 7-UM-250-KPR	E Fe9

Characteristics and typical fields of application

WEARstick MnCr13 is suitable for claddings on parts subject to highest pressure and shock in combination with abrasion. Surfacing can be made on ferritic steels as well as austenitic hard Mn-steels and joints of hard Mn-steels can be welded.

Main application fields are in mines, quarries, cement industry, railways and steel works, where working parts are regenerated, such as breaker jaws, hammer crushers, switches and crossings.

Fully austenitic structure. Due to the addition of Cr, increased resistance against friction and corrosion. Very high work hardening and high toughness.

Hardness of the pure weld deposit:

After welding: approx. 260 HB

After work hardening: 48 - 53 HRC

Typical analysis

	C	Si	Mn	Cr	Fe
wt.-%	0.6	0.8	16.5	13.5	bal.

Operating data

	Polarity	DC + / AC	Dimension mm	Current A
	Redrying	2h / 300°C	3.2 × 350	110 – 150
			4.0 × 450	140 – 190
			5.0 × 450	190 – 240

Welding instructions

Hold the stick electrode vertically. Weld at a low temperature and keep interpass temperature below 250°C. It is recommended to weld short beads and to avoid overheating.

Re-drying: 2h/300 °C

Approvals

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