

DESCRIPTION

Dynamang deposit is an austenitic manganese steel containing chromium and some nickel. It produces a tough, high-strength deposit that work hardens under impact. It is primarily used for the build up, repair, and joining of manganese steel components in the rock-crushing and mining industries. Deposit thickness is unlimited and can be flame cut without difficulty.

TYPICAL DEPOSIT CHARACTERISTICS

Hardness:	
As Deposited	231 BHN
Work Hardened	42 HRC
Deposit Layers	Multiple
Surface Cross Checks	No
Machinability	No
Magnetic	No
Limit on Interpass Temperature	500EF Max.
Tensile Strength	119 Ksi (820 MPa)
Yield Strength	89 Ksi (615 MPa)
Elongation	21%

ALLOY TYPE

Austenitic Manganese Steel

TYPICAL APPLICATIONS

- Crusher rolls
- Jaw and hammer crushers
- Manganese buckets and teeth
- Dredge pump cutters
- Shovel pads
- Gyratory crusher mantles

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	.045 (1.2)
Current, Amp. DCEP	150 – 180
Voltage	25 – 27
Position	Flat
Wire Extension	1/2" – 3/4"
Shielding Gas	None or CO ₂

Diameter, In. (mm)	1/16 (1.6)
Current, Amp. DCEP	200 – 250
Voltage	23 – 27
Position	Flat
Wire Extension	1/2" – 1"
Shielding Gas	None or CO ₂

Diameter, In. (mm)	7/64 (2.8)
Current, Amp. DCEP	275 – 375
Voltage	25 – 28
Position	Flat
Wire Extension	3/4" – 1 1/4"
Shielding Gas	None

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
.045" (1.2mm)	33# Wire Basket	11836400
1/16" (1.6mm)	33# Wire Basket	11446700
1/16" (1.6mm)	50# Poly Pak	11470200
7/64" (2.8mm)	60# Coil	11249900
7/64" (2.8mm)	110# Quarter Pak	11250100
7/64" (2.8mm)	200# Half Pak	11250200