

DESCRIPTION

Foundry Co-Mang is an austenitic manganese steel deposit which is suitable for multi-layer build-up and has excellent work hardening characteristics. It can also be used to join austenitic manganese steels.

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	Yes
Austenitic	Yes

ALLOY TYPE

Austenitic Manganese Steel

TYPICAL APPLICATIONS

- Rock Crushing and Mining
- Dredge Pump Parts
- Hammer Mill Hammers
- Shovel Pads
- Cursher Rolls, Jaw, Grizzly Bars
- Screens, Grates, Impactor Bars
- Manganese Railroad Frogs
- Latch Pins

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	1/16 1.6)
Current, Amp. DCEP	200 – 250
Voltage	24 – 26
Position	Flat
Wire Extension	3/4" – 1 1/4"
Shielding Gas	None

Diameter, In. (mm)	3/32 (2.4)
Current, Amp. DCEP	225 – 275
Voltage	25 – 27
Position	Flat
Wire Extension	1 1/4" – 1 1/2"
Shielding Gas	None

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/16" (1.6mm)	33# Wire Basket	11847800
1/16" (1.6mm)	50# Poly Pak	11863600
3/32" (2.4mm)	60# Coil	11908300