

## Dur Mn14

**CATEGORY** SMAW Stick Electrodes

**TYPE** Basic coated electrode with high impact resistance.

**APPLICATIONS** This electrode with a recovery of 140% can be used for joining and overlay on manganese steels that are worn out and need to be rebuilt. Heat input should be low.

**PROPERTIES** There is no limit for the number of layers that can be applied in case of rebuilding but heat input should be kept low (as for Mn steel). The weld deposit is offers strain hardening properties from 250 till 450 HB

**CLASSIFICATION**

AWS	A 5.13:E FeMn-A
EN ISO	14700: E Fe9
DIN: W.Nr.	1.3402
DIN	8555: E 7-UM-250-K

**SUITABLE FOR** austenitic manganese steel, high impact loads, hammers, crushers, rebuilding, hardfacing, rails, crossings, Breaker teeth, etc..

**APPROVALS** CE Approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

C	Mn	Ni	Fe
< 0.8	12-14	< 3	bal

**MECHANICAL PROPERTIES**

Heat Treatment	Rp0,2 (N/mm <sup>2</sup> )	Rm (N/mm <sup>2</sup> )	A5 (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW							220-450

AW: as welded, 450 HB after cold strengthened

**WELDING PARAMETERS / PACKING**

D (mm)	Welding Parameters			Packing	
	Length (mm)	Current (A)	kg / can	kg / 6 pack	
3.2	450	100-160	3.5	21	
4.0	450	160-220			
5.0	450	190-260			

**REDRYING TEMPERATURE** 300°C / 2hr