HADMOLOY 140

Tough austenitic steel electrode for cushioning and build up of Hadfield manganese steel. Deposits are tough and work harden under repeated impact.

Applications:

Pulverizer hammers, bucket teeth, sprockets, chain links, track pads and crusher mantles.

Procedure:

Degrease to remove oil & grease. Gouge out / Grind cracks, damaged and fatigued metal. Use AC/DC+ at lowest possible amps. Maintain short arc and deposit stringer beads using skip and staggered welding sequences. Chip slag between passes. Water quench deposits and does not allow Manganese Steel temperature to go beyond 250º C.

Technical Data: HADMOLOY 140

Size (mm), Ø: 3.15 4.00 5.00

Recommended Welding Current (Amps): 80 - 120 120 – 160 150 - 200

Hardness (As Deposited): 180 – 220 BHN
(Work Hardened): 400 – 450 BHN

Tensile Strength: 80 kgf / mm²

Yield Strength: 52 kgf / mm²