

HADMOLOY 1400

Description:

Hadmoloy 1400 is a specially formulated Ni-Cr-Mn type anti-wear electrode suited for particularly high strength, tough, crack and wear-resistant joints. Especially recommended for joining mild steel to manganese steel and cushioning of Hadfield manganese steel prior to hardfacing with hard alloys.

Applications:

An alloy specially designed for the positional joining of manganese steel parts. Recommended for Pulverizer hammers, bucket teeth, sprockets, chain links, crusher mantles, crusher rollers, crusher jaws, bucket latch bars and keys, wear plates, wobblers, jammer mills and shovel track pads.

Procedure:

Gouge out / Grind cracks, damaged and fatigued metal. Employ short stringer beads. Use skip and staggered welding sequences. Chip slag between passes. Water quench deposits and do not allow the temperature of Manganese Steel to go beyond 250° C.

TECHNICAL DATA	:	HADMOLOY 1400		
Size (mm), Ø	:	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	100 - 120	120 – 160	150 - 200
Hardness (As Deposited)	:	180 – 200 BHN		
(Work Hardened)	:	400 – 450 BHN		

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