

AMTEC 40 BUILD-UP MANGNESE STEEL

DC REVERSE OR AC ELECTRODE



General Characteristics

Amtec 40 Chrome Nickel Manganese is a high alloy electrode for joining and build-up of Austenitic Manganese Steels for extreme impact resistance. This alloy is for joining and rebuilding manganese parts. The high alloy deposits are very tough and will take extreme impact especially in the work hardened condition. This electrode has excellent weldability with very low spatter. Can be used in all positions.

Hardness (RC) - **16-19**
as deposited
Hardness (RC) - **48-50**
work hardened

Diameter		Amps(approx.)
(Inch)	(MM)	
1/8	3.25	110-135
5/32	4.0	125-190
3/16	5.0	150-220
1/4	6.0	190-250

Procedure

Clean the welding zone free from oil, rust and other contaminants. Maintain a short to medium arc and weave slightly to obtain a smooth even deposit. Deposit 3 to 4 inches at a time to minimize heat input. Skip welding technique is advisable on large components. It is recommended to keep the manganese part being welded below 500°F, so that the structure of the manganese base metal is not altered. Allow welded part to cool slowly.

Application

For build-up and joining of manganese parts, such as crusher rolls, dipper lips and teeth, dredge pump parts, crusher jaws, shovel pads, and any other parts of heavy equipment that are austenitic manganese steel.