

SUNHARD MN

Hard Facing Electrode

CHARACTERISTICS

SUNHARD MN is a heavy coated basic type austenitic manganese (12%) steel electrode specially designed for reconditioning of austenitic manganese steel parts. The weld metal has good resistance to metal to metal wear and moderate impact.

APPLICATIONS

Ideally suited for welding of crusher jaw, manganese steel rails, rail cross-overs, cement grinders rings, austenitic manganese steel castings and hammers etc.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon
0.82	12.8	0.62

HARDNESS TYPICAL

As welded : 188 BHN
After work hardening : 489 BHN

CURRENT RANGE & PACKING DATA:

Size (mm)	Length (mm)	Current(Amp) AC or DC(+)	Quantity of Electrodes in a Carton	Quantity of Electrodes in a Cardboard box
3.15	450	100-120	5 Kg	20 Kg
4.00	450	140-180	5 Kg	20 Kg
5.00	450	180-220	5 Kg	20 Kg

RECOMMENDATIONS:

Use dry electrodes at the lowest possible current. While reconditioning of worn out parts, the hardened layer should be ground out. Peening is must.