

LH 713



AUSTENITIC MANGANESE STEEL
ELECTRODE FOR HIGH IMPACT
RESISTANCE

PROPERTIES

The deposit is work-hardening and highly resistant to cracking and deformation during working. Excellent abrasion resistance in the work-hardened condition. Enhances component life against impact and abrasion simultaneously.

PROCEDURE

Ensure proper cleaning of the affected area. Remove the fatigue material by gouging with LH 900. Do not preheat Manganese Steel. Temperature should be kept below 150°C using staggered or skip welding techniques. Hot peening helps reducing stresses. Small components can be immersed in water for controlling the temperature.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	40-70
	3.2x350	100-130
	4.0x350	120-170
	5.0x350	160-210

TYPICAL APPLICATIONS

For joining manganese steel/ Hadfield steel parts and hardfacing of parts subject to heavy impact and stress. Recommended for crushing equipment parts like rocks, jaws, cones, gyratory crushing mantles, excavator teeth, manganese rails, hammers, buckets, etc.



SPECIFICATIONS

ALLOY BASIS: Mn, Ni, Cr



TECHNICAL DATA

Hardness as welded 17 HRC
work hardened 40-45 HRC