


FC 14 Mn DC+

BUILD-UP
DESCRIPTION

Open arc build-up wire. Work-hardening austenitic manganese flux-cored wire alloyed with chromium and nickel for improved weld deposit properties over standard manganese alloys. It is designed for build-up and fabricating of manganese steel or carbon steels and low alloy steels. **Deposits are very tough, and work-hardens rapidly in-service** as plastic deformation occurs during impact. **Deposit can be flame cut.**

TOTAL ALLOY CONTENT: 20 % (Carbon, Silicon, Manganese, Chromium, Nickel)

TYPICAL APPLICATIONS

Build-up of crusher jaws, cones and roll shells, gyratory crusher mantels, hammer mill and impact breaker bars, railroad track components. Joining of manganese steel components.

PROCEDURE

When welding out-of-position it is better to use a shielding gas of 100% CO₂ at 40-45 cfm and DC Straight Polarity. Parameters: **.045"** - 23 volts, 270 ipm, 3/4" stick-out **1/16"** - 21 to 22 volts, 200 ipm, 3/4" stick-out.

MECHANICAL PROPERTIES

Hardness (as-welded): 20 - 22 HRC Work hardening: 50 - 55 HRC
Deposit thickness: Unlimited

WELDING PARAMETERS

| | | |
|------------|------------------|----------------|
| Diameter: | 1/16" (1.6 mm) | .045" (1.2 mm) |
| Voltage: | 23 - 28 V | 19 - 27 V |
| Amperage: | 150 - 300 A | 100 - 200 A |
| Stick out: | 1" - 1 1/2" | 3/4" - 1 1/4" |
| Packaging: | Spool of 11,4 kg | |

Other diameters available on request.

Electrodes also available: **Selectarc HB 14 Mn**

Rev.: 21_08

Specialized welding alloys and technology. For technical assistance or for ordering: