



SelectWear MN

Description

SelectWear MN is an austenitic manganese steel wire. It produces a tough, impact resistant deposit that work hardens in use (the as deposited hardness of R_C20 will increase to R_C40-50). It is designed for severe impact and moderate abrasion. **SelectWear MN** is primarily used for the buildup and repair of manganese steel components. The deposit thickness is unlimited and has very good crack resistance.

Alloy Group

Austenitic Manganese Steel

Applications

Designed for buildup and repair: Manganese steel rock crushing hammers, rolls, buckets and teeth, impactor bars, gyratory mantles and dredge components

Deposit Properties

- Chemistry: Fe-Mn-Cr-C
- Hardness: As welded - R_C20, work hardens to R_C40-50
- Non-machinable
- Will not cross crack

Recommended Welding Parameters

MN-FCG - Gas shielded flux cored wire (CO₂ or Ar-25% CO₂)

<u>Diameter</u>	<u>Polarity</u>	<u>Current (amps)</u>	<u>Voltage</u>	<u>ESO</u>
.045"	DCRP	150-220	24-29	½"-1"
1/16"	DCRP	180-275	26-30	¾"-1¼"
5/64"	DCRP	240-400	26-32	¾"-1¼"
3/32"	DCRP	280-400	26-33	1"-1¼"
7/64"	DCRP	300-400	27-32	1¼"-1¾"
1/8"	DCRP	400-450	29-33	1¼"-1¾"

Note: Listed parameters are for CO₂ shielding. Lower by one volt for Ar-25% CO₂.

MN-FCO - Open arc, flux cored wire

1/16"	DCRP	200-250	26-30	¾"-1¼"
7/64"	DCRP	300-400	26-31	1¼"-1¾"

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Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field.