

Specifications & Properties:

Tensile Strength: 129,000 psi
 Yield Strength: 93,000 psi
 Hardness as Deposit: HRC 18-23
 Work Hardened: HRC 50-55
 Elongation 2": 40%
 Impact Resistance: High
 Abrasive Resistance: Fair

Welding Parameters

Diameter: 1/8" 5/32" 3/16"
 Current: DCRP DCRP DCRP
 Amperage: 125-140 140-160 175-200

Description:

Mangweld 44 is an electrode that can be used for overlay or build-up on carbon and low alloy steels as well as manganese steel. It is excellent for work hardening high chromium austenitic manganese steel. Deposits are very tough and work hardens rapidly under high impact. Typical applications include railroad crossings, hammer mill hammers, impactor bars.

Available in multiple sizes and diameters.

Typical Chemical Composition (Wt%)

C	Mn	Si	Cr	Ni	Fe
0.3	16.0	0.3	15.0	0.5	BAL

Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.

CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.