

Supershield 16Mn-0

High Mn Type

Conformances

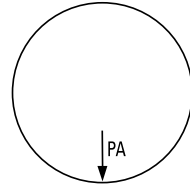
Applications

- Crusher rolls and hammers, cone mills

Features

- Open arc type hardfacing wire(buffer layer)
- High-Mn type

Welding Position



Current

DC +

Welding Process

Open Arc

Diameter / Packaging

Diameter	Spool		Coil	Pac			
	mm (in)	12.5kg (27.6lbs)		15kg (33lbs)	25kg (55lbs)	150kg (330lbs)	250kg (551lbs)
1.2 (0.045)							
1.6 (1/16)							
2.4 (3/32)			√	√	√		
2.8 (7/64)			√	√	√		
3.2 (1/8)							

Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	Cr
As welded with 1.6/2.4/2.8mm wire	0.5	0.5	17.0	3.5

Typical Mechanical Properties of All-Weld Metal

	Rockwell Hardness(HRC) (≥3layers)	
	As welded	Work hardened
On Mild Steel (1.6/2.4/2.8mm)	15~20	40~50

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
2.4mm (3/32 in) DC+					
Open Arc	25 (1)	3.6 (144)	310	26	4.3 (9.4)
		4.7 (185)	360	28	6.1 (13.4)
		6.1 (242)	410	30	8.4 (18.5)
2.8mm (7/64in), DC+					
Open Arc	25 (1)	2.9 (114)	330	27	5.2 (11.4)
		3.3 (130)	360	29	5.8 (12.7)
		3.8 (149)	400	30	6.8 (14.9)