

Classification: E188MnR73X (ISO3581-A/EN

E307-26 (AWS)

Properties :

High-yield rutile-basic electrode (160%) depositing an austenitic stainless steel with manganese. Great ease of use, gentle fusion with few projections, self-detachable dairy, very nice appearance of the cord. Nutty deposit by pressure and friction, characterized by good cracking resistance and easy machining when not nutied.

Applications :

Assembling and reloading manganese steels (up to 14% Mn), heterogeneous assemblages between steels of different shades or steels deemed difficult to weld.

Underlay before recharging, repair of any parts subject to shocks.

TP, rails, switches, railway tracks, cement plants, armour plates, digger buckets, crusher jaws, etc.

Mechanical characteristics :

| | | | |
|------------------------------|-------------------------------|----------------|--|
| $R_{p0,2} > 400 \text{ MPa}$ | $R_m = 600 - 750 \text{ MPa}$ | $A_5D > 30 \%$ | $KV > 70 \text{ J à } + 20 \text{ °C}$ |
|------------------------------|-------------------------------|----------------|--|

Hardness : ~200 HB nuttyable at ~500 HB.

Packaging / Welding recommendations :

| | | | |
|------------------------|-----|-----|-----|
| Ø mm | 2,5 | 3,2 | 4 |
| Poids étui (kg) | 4 | 5 | 5 |
| Intensité (A) | 90 | 130 | 160 |

- Continuous current (- to the electrode), or alternative (Uo - 50V).
- Heating process 2h at 250 °C if necessary. • Heating process : 1h to 250 - 300 °C

| | | | | | | |
|----------------|-----|----|-----|-----|-----|-----|
| Ø mm | 1,6 | 2 | 2,5 | 3,2 | 4 | 5 |
| Ampères | 30 | 50 | 70 | 100 | 140 | 170 |

Welding process :

