

Standards

TS EN ISO 3581 - A	: E Z 18 9 MnMo R 53
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AWS A5.4	: ~E 307-26

Mechanical Properties

Tensile Strength (N/mm ²)	Elongation ((L ₀ =5d ₀) (%))	Hardness (HB)	
		As Welded	After Working
600 - 700	min. 40	220	410

Features and Applications

- Rebuilding or buffering before hardsurfacing and surfacing of rails and railway equipments
- Welding 12-14 % Manganese steels, armour and hard to weld steels
- In cement industry for welding buffer layer of mili hammers, rollers and friction plates of crushers etc
- Rutile type austenitic electrode containing 18 Cr / 8 Ni with manganese
- The corrosion resistant weld metal is also resistant to impact, pressure, cavitation and thermal shocks
- Weld metal hardness increases by cold forming and work hardening

Welding Positions



Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Package Weight (Kg)	Weight g / 100 pcs
3030100037	3.20 x 350	1/8 x 14"	90-130	5	5050
3030100038	4.00 x 350	5/32 x 14"	130-160	5	7500
3030100039	5.00 x 350	3/16 x 14"	160-190	5	11500

Approvals: CE, SEPRO