

## HADMOLOY 140

Tough austenitic steel electrode for cushioning and build up of Hadfield manganese steel. Deposits are tough and work harden under repeated impact.

### Applications:

Pulverizer hammers, bucket teeth, sprockets, chain links, track pads and crusher mantles.

### Procedure:

Degrease to remove oil & grease. Gouge out / Grind cracks, damaged and fatigued metal. Use AC/DC+ at lowest possible amps. Maintain short arc and deposit stringer beads using skip and staggered welding sequences. Chip slag between passes. Water quench deposits and does not allow Manganese Steel temperature to go beyond 250° C.

<b><u>Technical Data</u></b>	<b>:</b>	<b>HADMOLOY 140</b>		
Size (mm), Ø	:	3.15	4.00	5.00
Recommended Welding Current (Amps):	:	80 - 120	120 – 160	150 - 200
Hardness (As Deposited)	:	180 – 220 BHN		
(Work Hardened)	:	400 – 450 BHN		
Tensile Strength	:	80 kgf / mm <sup>2</sup>		
Yield Strength	:	52 kgf / mm <sup>2</sup>		

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