

**DESCRIPTION**

Stoody Nicromang deposit is an austenitic manganese steel with excellent impact strength. It has a high deposition rate and work hardens under impact. Deposits can be flame cut. It is designed for build up and joining of manganese steels and is not recommended for buildup of carbon steels. There is no limit to deposit thickness. When welding, the interpass temperature should not exceed 500°F.

**TYPICAL DEPOSIT CHARACTERISTICS**

Abrasion Resistance	Moderate
Impact Resistance	Excellent
Hardness as Deposited	200 HB
Hardness as Work Hardened	HRC 52
Magnetic	No
Surface Cross Checks	No
Machinability	Poor
Deposit Layers	Unlimited
Maximum Interpass Temperature	500°F

**ALLOY TYPE**

Austenitic Manganese Steel

**TYPICAL APPLICATIONS**

- Railroad Frogs and Crossings
- Crusher Equipment Parts
- Manganese Steel Castings
- Wobbler Spindles
- Coupling Boxes

**OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS**

Diameter, In. (mm)	<b>1/8 (3.2)</b>	<b>5/32 (4.0)</b>
Current, Amp. DCEP	100 – 160	140 – 200
Position	Flat / Horizontal	Flat / Horizontal
Rod Length	14"	14"

Diameter, In. (mm)	<b>3/16 (4.8)</b>	<b>¼ (6.4)</b>
Current, Amp. DCEP	170 – 225	230 – 330
Position	Flat	Flat
Rod Length	14"	18"

Diameter, In. (mm)	<b>5/16 (8.0mm)</b>
Current, Amp. DCEP	270 – 390
Position	Flat
Rod Length	14"

**STANDARD SIZES**

Diameter	Packaging	Part #
1/8" (3.2mm)	60#	45150850
1/8" (3.2mm)	10#	45150810
5/32" (4.0mm)	60#	45151050
5/32" (4.0mm)	10#	45151010
3/16" (4.8mm)	60#	45151250
3/16" (4.8mm)	10#	45151210
¼" (6.4mm)	60#	45151650
¼" (6.4mm)	10#	11498800
5/16" (8.0mm)	60#	45152050