

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 Diamotor In (mm) 410 (0 0)

Diameter, In. (mm) Current, Amp. DCEP Position Rod Length	1/8 (3.2) 100 – 160 Flat / Hori- zontal 14"	5/32 (4.0) 140 – 200 Flat / Hori- zontal 14"
Diameter, In. (mm) Current, Amp. DCEP Position Rod Length	3/16 (4.8) 170 – 225 Flat 14"	1⁄4 (6.4) 230 – 330 Flat 18"
Diameter, In. (mm)	5/16 (8.0mn	n)

	5/10 (0.011
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



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NOTICE - Failure to follow manufacturer's directions for use may result in equipment or material failure and void any applicable warranty. The data provided or referenced herein is provided for informational purposes only, without guarantee or warranty and represents "typical" results when Stoody products are used in accordance with internal Stoody procedures. Other tests and

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