

Eureka Welding Alloys

2000 E. Avis Drive

Madison Heights, MI 48071

Phone: 248-588-0001 Fax: 248-585-7711 Toll Free: 800-962-8560

E-mail: info@eurekaweldingalloys.com Website: www.eurekaweldingalloys.com

TECHNICAL DATA FOR EUREKA MANG ELECTRODE

Dated: March 31, 1995

Revised: July 8, 2013

INTRODUCTION

Eureka Mang Electrode is a smooth running rutile coated stick electrode for hard facing. The electrodes are designed for superior weldability having no spatter, a stable arc, good wet out, and easy slag removal.

METALLURGICAL CHARACTERISTICS

Eureka Mang Electrodes deposits are high in Manganese with additions of Carbon, Chromium, and Nickel. The deposits have an austenitic structure that is 20 HRC as deposited. The deposits work harden rapidly up to 50 HRC.

RECOMMENDED APPLICATIONS

Eureka Mang Electrodes are used in the buildup or joining of austenitic work hardening Manganese steels. The weld deposits are extremely resistant to high impact loads and severe abrasion. It is commonly used for the repair of railroad frogs, crushers, and shovel buckets.

Eureka Welding Alloys

2000 E. Avis Drive

Madison Heights, MI 48071

Phone: 248-588-0001 Fax: 248-585-7711 Toll Free: 800-962-8560

E-mail: info@eurekaweldingalloys.com Website: www.eurekaweldingalloys.com

WELDING PARAMETERS

SIZE	AMPERAGE RANGE
3/32" 2.4mm	70 – 120
1/8" 3.2mm	100 – 140
5/32" 4.0mm	140 – 170
3/16" 4.8mm	170 – 225
1/4" 6.35mm	225 – 300
5/16" 7.94mm	300 – 375
3/8" 9.5mm	350 – 425

TYPICAL CHEMISTRY

C	Mn	Si	Cr	Ni
.80	16.0	.40	2.0	3.0

PHYSICAL AND OR MECHANICAL PROPERTIES

AS WELDED HARDNESS

20 HRC

Work Hardens to 50 HRC