

# S-13MN.B

AS/NZS 2576: 1220-A4

TYPE : Basic

## Applications

14%Mn steel type deposit for Crusher hammers, crusher jaws, crusher rolls and conveyor buckets.

## Characteristics on Usage

Good covering property and removability of the slag with low spatter loss. Beautiful bead appearance. Very high impact resistance. Good resistance to abrasion.

## Notes on Usage

- 1) Cool the weld metal with water during welding.
- 2) Austenite type stainless steel electrodes should be used for under-laying on the base metals other than 13% Mn steel.
- 3) Dry the electrodes at 350~400°C for 60 minutes before use.

## Surfacing Position



D/H Hor.

## Current

AC or DC +

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Mo
0.38	0.06	14.5	0.030	0.003	1.16	1.57

## Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp. °C	Postheat	Heat Treatment.	Hardness(HB)
R.T	-	-	220
	-	After work hardening	480

## Approval

## I Packing

Packet 5 kg  
Carton 5 kg x 4 : 20kg

## Sizes Available and Recommended Currents (Amp.)

Size mm (in)	3.2	4.0	5.0
Length mm(in)	350	400	400
Flat (A):	90~150	140~190	190~240

Diam.	5kg Pack
3.2mm	HKS-13MNB32
4.0mm	HKS-13MNB40

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