



## HARD FACING WELDING ELECTRODES

## RASI HF MANG-13

### TECHNICAL SPECIFICATION SHEET

#### CHARACTERISTICS

RASI HF MANG -13 is a low hydrogen type hard facing electrode yielding 12% to 14% Manganese in the weld deposit. The weld deposits which display excellent resistance to impact in combination with corrosion.

#### APPLICATIONS

Used on a wide range Similar and dissimilar steels, such as joining of austenitic manganese steel to themselves and to ferritic steels. For welding of heat treatable alloy steels for fabrication welding, maintenance and reclamation of worn out parts, both for buffer layer and hard facing in mining , cement, steel, power plant, earth moving machinery and welding 14% Manganese steels etc.

#### HARDNESS

As Welded : 200 BHN.  
work hardeness 500 - 550 BHN.

#### CHEMICAL COMPOSITION OF ALL WELD METAL

CANNOT BE DISCLOSED.

#### HINTS ON WELDING

No preheating necessary for mild steel jobs  
Clean the weld area thoroughly free of any foreign matter  
Use low current  
Short arc and stringer bead.

#### WELDING CURRENT : AC / DC (-)

Ø 3.15 mm - 100-140 Amps  
Ø 4.00 mm - 140-180 Amps  
Ø 5.00 mm - 180-220 Amps.

**\*FOR APPROVALS AND CERTIFICATIONS KINDLY CONTACT :- [info@rasielectrodes.com](mailto:info@rasielectrodes.com)**

\*All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

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