



## PHILARK PH 14 MN

*Coated Electrode for Build Up & Hardfacing Applications*



### General Description

PHILARK PH 14 MN is a basic coated which electrode which deposits weld metal containing manganese and nickel. The deposit has a reduced tendency for cracking and heat embrittlement compared with plain 12 – 14% manganese weld metal. Suitable for building up worn 14% manganese steel components.

### Mechanical Properties of Weld Metal

Hardness:

As deposited : 15-25 HRc

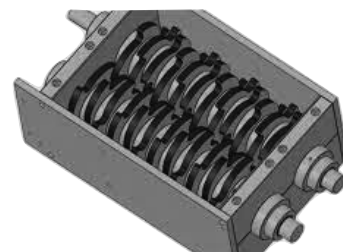
Work Hardened : 35-45 HRc

Tensile Strength: 80 Kgf/mm<sup>2</sup>

Pressure	■	■	■	■	■
Impact	■	■	■	■	■
Abrasion	■	■	■	■	■

### Typical Applications

- Surfacing of boring mills
- crusher teeth
- dipper teeth
- rail crossings
- filling up cavities of high manganese cast iron
- Track rollers
- Drive Sprocket Wheels



Roll Crushers

### Welding Parameters

Current Type and Polarity : AC/DC(+),

Welding Positions: Flat, Vertical, Overhead.

Diameter [ mm ]	3.15	4.0	5.0
Length [ mm ]	350	350	450
Current [ A ]	130-160	150-180	170-200

PHILARK ALLOYS

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