



PHILARK PH NIMN

Coated Electrode for Build Up Applications



General Description

PHILARK PH NiMn is a basic coated electrode designed to provide a non-magnetic austenitic 11 - 14% manganese deposit for service involving high impact. The deposits are extremely tough, non-porous, crack-free and work hardened readily under impact loading to approximately 440 - 600 HV (45 - 55 HRc). The electrode is recommended for downhand welding only

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

Mechanical Properties of Weld Metal

Hardness:

As deposited : 25 HRc

Work Hardened : 45-55 HRc

Typical Applications

Although primarily intended for reclaiming worn parts made from 11 - 14% manganese steel (Hadfield manganese steel), PHILARK PH NiMn can also be used for joining this material or hardfacing carbon steel components subject to severe impact loads. Under these conditions, an austenitic stainless steel buffer layer should be applied. This electrode can be used on cast manganese steel railway crossings, dredger buckets, crusher jaws, swing hammers, blow bars and grizzlies



Blow Bars

Welding Parameters

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

Welding Positions: Flat.

Diameter [mm]	3.15	4.0	5.0
Length [mm]	350	350	450
Current [A]	100-130	130-170	170-220

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