



NH 99 Hardfacing Electrodes

Rebuilding of steel with 12% - 14% manganese. Mining-material, railroad, crossing, switches, recommended for metal to metal wear very ideal for hadfield austenitic manganese steels. Hardness :40-45 H.R.C

- Special features :**
- 1) Excellent abrasion resistance, yet the weld deposit is soft, flexibility is good.
 - 2) Shock and impact resistance.
 - 3) Deposit is non-magnetic.
 - 4) The manganese content is more than 13%.
 - 5) Deep penetration.
 - 6) Easy slag removal.

TYPICAL ANALYSIS OF ALL-WELD METAL DEPOSIT

Element	<u>C</u>	<u>Si</u>	<u>Mn</u>	<u>P</u>	<u>S</u>	<u>Ni</u>	<u>Cr</u>
Deposited Metal %	0.68	0.28	13.2	0.04	0.02	1.98	0.05

- Uses :**
- 1) Stone crusher (quarry).
 - 2) Paper mill.
 - 3) Railway track.
 - 4) Food processing, sugar mill.
 - 5) Hammer mill.
 - 6) Cement plant.

- Ampere setting :** AC and DC +
- | | |
|--------|---------------|
| 3.2 mm | 100 - 120 amp |
| 4.0 mm | 130 - 160 amp |



Worn-out saw plate at granite quarry



Build up by NH 99/final of NH 33