

# Supershield 16Mn-0

High Mn Type

## Conformances

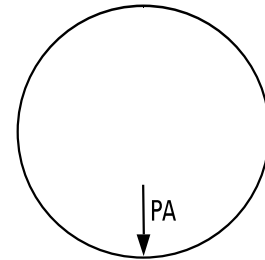
## Applications

- Crusher rolls and hammers, cone mills

## Features

- Open arc type hardfacing wire(buffer layer)
- High-Mn type

## Welding Position



## Current

DC +

## Welding Process

Open Arc

## Diameter / Packaging

Diameter	Spool		Coil	Pac		
	12.5kg (27.6lbs)	15kg (33lbs)		150kg (330lbs)	250kg (551lbs)	350kg (771lbs)
mm (in)						
1.2 (0.045)						
1.6 (1/16)						
2.4 (3/32)			√	√	√	
2.8 (7/64)			√	√	√	
3.2 (1/8)						

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

	C	Si	Mn	Cr
As welded with 1.6/2.4/2.8mm wire	0.5	0.5	17.0	3.5

## Typical Mechanical Properties of All-Weld Metal

	Rockwell Hardness(HRc) ( $\geq 3$ layers)	
	As welded	Work hardened
On Mild Steel (1.6/2.4/2.8mm)	15~20	40~50

## Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
<b>2.4mm (3/32 in) DC+</b>					
Open Arc	25 (1)	3.6 (144)	310	26	4.3 (9.4)
		4.7 (185)	360	28	6.1 (13.4)
		6.1 (242)	410	30	8.4 (18.5)
<b>2.8mm (7/64in), DC+</b>					
Open Arc	25 (1)	2.9 (114)	330	27	5.2 (11.4)
		3.3 (130)	360	29	5.8 (12.7)
		3.8 (149)	400	30	6.8 (14.9)