

S-13MN.B

Type : Basic

Conformances

JIS Z3251 DFMA-250-B

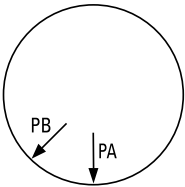
Applications

- Light impact abrasion, crusher hammers, jaws, rolls and buckets

Features

- High impact resistance
- Good resistance to abrasion
- Mostly suitable for soil abrasion
- Cutting properties impossible
- Easy to remove slag

Welding Position



Current

AC or DC ±

Redrying Conditions

350°C (662°F) X 1 hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard	
		packet 5kg(11lbs)	carton 20kg(44lbs)
2.6 (3/32)	350 (14)		
3.2 (1/8)	350 (14)		✓
4.0 (5/32)	400 (16)		✓
5.0 (3/16)	400 (16)		✓
6.0 (15/64)	450 (18)		✓

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Mo
0.38	0.06	14.5	0.030	0.003	1.16	1.57

Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp.°C(°F)	Postheat	Heat Treatment	Hardness (HB)
RT	-	-	220
	-	After work hardening	480

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm (in)	350 (14)	400 (16)	400 (16)	450 (18)
F & HF	90~140	140~190	190~240	220~300