

STOODY® NICROMANG® Shielded Metal Arc Welding Electrode

Stoody Nicromang deposit is an austenitic manganese steel with excellent impact strength. It has a high deposition rate and work hardens under impact. Deposits can be flame cut. It is designed for build up and joining of manganese steels and is not recommended for build of carbon steels. There is not limit to deposit thickness. When welding, the interpass temperature should not exceed 500°F.

TYPICAL MECHANICAL PROPERTIES

Abrasion Resistance	Moderate
Impact Resistance	Excellent
Hardness as Deposited, HB	200
Hardness as Work Hardened, HRC	52
Magnetic	No
Surface Cross Checks	No
Machinability	Poor
Deposit Layers	Unlimited
Maximum Interpass Temperature	500°F

ALLOY TYPE

Austenitic Manganese Steel

TYPICAL APPLICATIONS

- Railroad frogs and crossings
- Crusher equipment parts
- Manganese steel castings
- Wobbler spindles
- Coupling boxes

OPERATIONAL CHARACTERISTICS/WELDING PARAMETERS (DCEP)

1/8" (3.2 mm)	
Current, amp	100 – 160
Position	Flat/Horizontal
Length, in (mm)	14 (355)
5/32" (4.0 mm)	
Current, amp	140 – 200
Position	Flat/Horizontal
Length, in (mm)	14 (355)
3/16" (4.8 mm)	
Current, amp	170 – 225
Position	Flat/Horizontal
Length, in (mm)	14 (355)
1/4" (6.4 mm)	
Current, amp	230 – 330
Position	Flat/Horizontal
Length, in (mm)	18 (457)
5/16" (8.0 mm)	
Current, amp	270 – 390
Position	Flat/Horizontal
Length, in (mm)	18 (457)

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8" (3.2 mm)	60 lb (27.2 kg) Box	45150850
1/8" (3.2 mm)	10 lb (4.5 kg) Box	45150810
5/32" (4.0 mm)	60 lb (27.2 kg) Box	45151050
5/32" (4.0 mm)	10 lb (4.5 kg) Box	45151010
3/16" (4.8 mm)	60 lb (27.2 kg) Box	45151250
3/16" (4.8 mm)	10 lb (4.5 kg) Box	45151210
1/4" (6.4 mm)	60 lb (27.2 kg) Box	45151650
1/4" (6.4 mm)	10 lb (4.5 kg) Box	11498800
5/16" (8.0 mm)	60 lb (27.2 kg) Box	45152050
5/16" (8.0 mm)	10 lb (4.5 kg) Box	11941000

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NOTICE - Failure to follow manufacturer's directions for use may result in equipment or material failure and void any applicable warranty. The data provided or referenced herein is provided for informational purposes only, without guarantee or warranty and represents "typical" results when Stoody products are used in accordance with internal Stoody procedures. Other tests and procedures may produce differing results. Stoody expressly disclaims any liability resulting from reliance on this data.

PROTECT YOURSELF AND OTHERS - Users should read and follow all recommended guidance on health and safety from their employer, the supplier, the manufacturer, and government authorities. These, at a minimum including the Warning Labels on the products and the Safety Data Sheets ("SDS"). The SDS and additional safety information may be found on materials or links at: Stoody.com.