



# 730MnCr

EN 14700 T Fe9

## DESCRIPTION

Flux-cored wire for gas shielded metal arc hardfacing. It produces an austenitic, non-magnetic weld deposit which has excellent work hardening properties. It is used for rebuilding components exposed to severe impacts or heavy loads and can be welded on ferritic and austenitic steels including manganese steel. It forms an excellent buffer layer prior to hardfacing with high chromium cast iron. The deposit can be multi-layered without limit. Special applications: Railway frogs and crossings, hydraulic press pistons, crushing equipment, hammers, dredge pumps etc.

### WELDING POSITIONS



### CURRENT TYPE

DC(+)

### GAS

Ar/Co2(M21)/  
Self shielded

## MECHANICAL PROPERTIES

### Hardness

240HB after welding, work hardening up to 48 HRC

## TYPICAL CHEMICAL COMPOSITION(%)

C	Si	Mn	Cr
0,4	0,5	16,0	14,0

## PACKING INFORMATION AND WELDING PARAMETERS

Dimension(mm)	1,2	1,6	2,0	2,4
Spool(kg)	15/25/250	15/25/250	15/25/250	15/25/250
Current (A)	250	270	300	350
Voltage (V)	28	28	28	28
Stick-out(mm)	25	25	35	40

## EQUIVALENT CONSUMABLES

MMA	Meltolit HMnCr E
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