

MF 602

NON-SYNTHETIC, NON-MAGNETIC, HIGH MANGANESE FOR BUFFER LAYERS



- Extremely resistant to shock loading & impact
- Work hardens deep
- Suitable for all kinds of equipment overlays and build-ups
- Reduces replacement costs by build-up of worn components

SPECIAL BENEFITS

- **MF602** Is manufactured to provide outstanding re-building of wear parts of heavy construction and mining equipment
- **MF 602** Joins Manganese steels with ease
- **MF 602** Alloys withstand even the most severe shock, loading and impact
- **MF 602** Is an impact-Resistant Alloy that reconditions equipment to give a longer service life



MF-602

OUTSTANDING PROPERTIES:

- It is an impact-resistant alloy for manganese steel
 - Offers rare combination of toughness, crack resistance and impact resistance
Provides high yield strength welds
 - Has extremely high resistance to cracking
 - Suitable for depositing a work hardening type weld on austenitic manganese steels
 - Can be readily cut with an oxyacetylene torch
 - Sound elongation property
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- **MF 602** High manganese stainless steel electrode for joining manganese steels, to themselves as well as to other steel without preheat
- **MF 602** Is excellent for buffering & claddings on manganese steels as well as welding of hard to weld steels
- **MF 602** Joins armor steels to themselves as well as to mild, stainless and manganese steels
- **MF 602** Unique flux coating helps to remove slags completely

RECOMMENDED FOR:

- Tackling the tough jobs, where you need a super-hard surface that withstands the most severe conditions
- MF 602 can be used to join manganese steel to mild steel

Special Note:

Please note then welding manganese steel it should be welded as cold as possible this is to prevent this from forming Martensitic (Hard & Brittle) structure within the heat affected zone

In practical welding each weld seam should be cooled using water hose directly below the weld to avoid Martensitic Structure.

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MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	101,000 psi (690 N/mm ²)
Yield Strength	76,000 psi (510 N/mm ²)
Elongation	40%
Impact Energy	80J: +20°C
Hardness	Brinell 200, Rockwell C25
Work Hardness	Brinell 450, Rockwell C48

RECOMMENDED CURRENT: DC Reverse (+) or AC

RECOMMENDED AMPERAGE SETTINGS:

Diameter in (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	70	90	120
Maximum Amperage	90	120	150

WELDING POSITIONS: Flat, horizontal,

WELDING TECHNIQUES:

Never preheat manganese steels due to crack sensitivity.
Always use minimal amperage.

MF 500 - HIGH STRENGTH ALLOY WITH 5% SILICON FOR ALUMINUM

