

OK 14MnNi



Austenitic manganese steel electrode with nickel for surfacing and building up manganese steel components exposed to severe impact and moderate abrasion. The weld metal is less prone to embrittlement and cracking compared to plain austenitic manganese steel weld metal. Applications include: crusher plates and rolls, cones and mantels of rotary crushers, rail points.

Classifications:	EN 14700:E Z Fe9
Approvals:	CE , DB 82.039.08

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current:	AC, DC+
Alloy Type:	Austenitic Mn steel
Coating Type:	Zircon Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	440 MPa	690 MPa	30 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As welded	20 °C	100 J
As welded	-20 °C	80 J
As welded	-80 °C	45 J
As welded	-120 °C	25 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni
0.67	13.2	0.2	3.0

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
3.2 x 450 mm	100-160 A	30 V	0.54	27	90 s	1.5 kg/h
4.0 x 450 mm	130-210 A	30 V	0.54	18	105 s	2.0 kg/h
5.0 x 450 mm	170-300 A	31 V	0.56	11	114 s	2.9 kg/h