

# FN Mn

**International Standards:**

 DIN 8555 : E7 - UM - 200 KP  
 AWS A-5.13 : E FeMn-B

**Application & Properties:**

FONTA FN Mn is a manganese hardfacing electrode for wear resisting hard facing deposits. Weld metal will adopt high hardness by cold working. It is therefore particularly suited for parts which are subjected mainly to wear caused by heavy impact and shock. When building up various layers, it is good practice depositing a buffer layer with FONTA FN 37 or FN 307 weld metal. Suitable for: hardfacing and repair welding of wear resisting parts made of austenitic manganese steel, such as crusher jaw plates, crusher cones, pulverizing hammers, beating arms and others.

**Aplikasi & Penggunaan:**

FONTA FN Mn adalah kawat las hardfacing baja mangan untuk pengelasan hardfacing tahan gesek. Hasil las akan mengalami pengerasan sendirinya selama digunakan. Sangat cocok untuk pengelasan komponen yang aus karena benturan. Untuk pengelasan banyak layer, disarankan menggunakan buffer layer FONTA FN 37 atau FN 307. Sangat cocok untuk perbaikan komponen yang terbuat dari baja mangan austenitik, seperti: crusher jaw plates (gigi-gigi penghancur), pulverizing hammers (palu-palu penghancur), beating arms, dll.

**Typical Chemical Analysis of Deposited Metal (%) :**

C	Mn	Si	Cr
1,0	12	0,6	-

**Typical Mechanical Properties of Deposited Metal :**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation (%)	Hardness
-	-	-	200 HB (as welded) 400 - 500 HB (after work hardening)

**Size & Recommended Current Range (DC and AC) :**

Size (mm)	3,25 x 350	4,0 x 400	5,0 x 450
Amperages (Amp)	110 - 135	140 - 175	180 - 230
Weight / pack (kgs)	4,5	5	5
Weight / carton (kgs)	18	20	20

**Attention!**  
Redrying: 200°C / 2h

Manufactured by:

## PT. Lion Superior Electrodes

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