

NM

SPECIAL WELDING ROD FOR CARBON STEEL ALLOY AND FOR CAST IRON. MAXIMUM IMPACT RESISTANCE.

APPLICATIONS: The physical characteristics of the filler metal from this welding rod has led to its successful application wherever high abrasion and impact resistance are indispensable. Its main applications are reconditioning of bucket claws in excavators, excavator caterpillar wheels, mill parts, bolts, links and buckets in dredgers, railway elements, hooks, chains, etc..

CHARACTERISTICS AND PROCEDURE: NM is a welding rod suitable to recondition parts made out of manganese austenitic steel. Its fusion is homogeneous with minimal splatter. Its filler metal deposits harden as they cool down with the air. Its abrasion and impact resistance equals that of heat treated cast manganese steel. Its filler metal deposit hardens with impact and constitutes a surface which is impact and abrasion resistant. To achieve the best possible results with this NM electrode the following steps are recommended:

Clean the joint area. Set the AMP to ensure good fusion and avoid overheating the base metal by using alternate weld beads. On occasions, it may be necessary to cool down the part with water but do not wet the joint area. When more than two cladding layers are required to restore the part original dimensions, you should use Vilchis 30 for the intermediate layer. This will reduce the possibility of cracks and the dilution of NM.

FILLER METAL HARDNESS:	200 BRINELL
WORKING HARDNESS:	500 BRINELL
POSITIONS:	ALL
CURRENT:	DC REVERSE POLARITY AND AC
ABRASION RESISTANCE:	EXCELLENT

FILLER METAL CHEMICAL ANALYSIS %				SIZES	AMPERAGE
C	Mn	Si	Ni	3.25 mm - 1/8"	100-130
0.60	11-12	0.80	3.20	4.0 mm - 5/32"	160-180
				5.0 mm - 3/16"	200-250