

# S-13MN.B

Type : Basic

## Conformances

JIS Z3251 DFMA-250-B

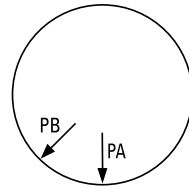
## Applications

- Light impact abrasion, crusher hammers, jaws, rolls and buckets

## Features

- High impact resistance
- Good resistance to abrasion
- Mostly suitable for soil abrasion
- Cutting properties impossible
- Easy to remove slag

## Welding Position



## Current

AC or DC ±

## Redrying Conditions

350°C (662°F) X 1hr

## Diameter / Packaging

| Diameter    | Length   | Standard   |             |
|-------------|----------|------------|-------------|
|             |          | packet     | carton      |
|             |          | 5kg(11lbs) | 20kg(44lbs) |
| 2.6 (3/32)  | 350 (14) |            |             |
| 3.2 (1/8)   | 350 (14) |            | √           |
| 4.0 (5/32)  | 400 (16) |            | √           |
| 5.0 (3/16)  | 400 (16) |            | √           |
| 6.0 (15/64) | 450 (18) |            | √           |

## Typical Chemical Composition of All-Weld Metal (%)

| C    | Si   | Mn   | P     | S     | Cr   | Mo   |
|------|------|------|-------|-------|------|------|
| 0.38 | 0.06 | 14.5 | 0.030 | 0.003 | 1.16 | 1.57 |

## Typical Mechanical Properties of All-Weld Metal

| Preheat & Interpass Temp. °C(°F) | Postheat | Heat Treatment       | Hardness (HB) |
|----------------------------------|----------|----------------------|---------------|
| RT                               | -        | -                    | 220           |
|                                  | -        | After work hardening | 480           |

## Typical Welding Parameters / Amp.(A)

| Diameter mm (in) | 3.2 (1/8) | 4.0 (5/32) | 5.0 (3/16) | 6.0 (15/64) |
|------------------|-----------|------------|------------|-------------|
| Length mm (in)   | 350 (14)  | 400 (16)   | 400 (16)   | 450 (18)    |
| F & HF           | 90~140    | 140~190    | 190~240    | 220~300     |