CH-90

For welding of 13%Mn steel

JIS Z3251 DFMA-200-B
DIN E7-250K

Applications

Hard-surfacing of crusher hammers, rail crossings and crusher jaws.

Characteristics

CH-90 is an electrode designed for abrasion resistance against heavy impact.
The weld metal becomes austenitic by water cooling during welding, which has excellent toughness and high work-hardening property.
It is suitable for fill-up cavities of high manganese cast iron because of its high toughness and crack resistance.

Notes on usage

(1) Water cool the weld metal during welding.
(2) Austenite type stainless steel electrodes should be used for under-laying on the base metal other than 13%Mn steel.
(3) When the base metal of 13%Mn steel is hardened, cut-off the hardened zone before welding.
(4) Dry the electrodes at 300~350℃ for 30~60 minutes before use.

Typical chemical composition of weld metal (%)

C	Mn	Si
0.82	13.40	0.52

Typical hardness of weld metal

Vickers hardness (Hv)	
As Welded	After work-hardening
220	510

Size & recommended current range (AC or DC +)

Dia. (mm)		3.2	4.0	5.0	6.0
L (mm)		350	400	400	450
Amp.	F	90-130	140-180	190-240	220-300

• Tip Color : Yellow