

<u>Parameters:</u>					<u>Characteristics:</u>
Diameter:	1/8"	5/32"	3/16"	1/4"	Deposit Layers: Multiple
Current:	DCRP	DCRP	DCRP	DCRP	Machinability: Poor
Amperage:	125-140	140-160	175-200	200-250	Hardness as deposited: 15-22
					Work Hardened: 45-50
					Tensile Strength: 144,000 psi

Description:

Weldman 1 is a manganese electrode that is often used for build-up or joining manganese, low alloy and carbon steels. It can also be used for joining austenitic manganese steels together. It is typically used to repair cracks in manganese castings as well as in impactor bars, crusher rolls, and railroad crossings. Weldman 1 deposits are very tough under high impact.

Weldman 1 has a high impact resistance, fair abrasive resistance, no surface cross check and no flame cut. The type of current is AC or DC, straight or reverse polarity.

Chemical Composition (Wt%)

Si	Mn	Ni	Cr	Fe	C
0.3	15.0	3.5	3.6	BAL	0.03

Note: Values are approximate

Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.

CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126; OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.