


Technical data sheet <small>011121MBA</small>	Cored welding wire ROBODUR M 13Mn-G	 Welding Alloys
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CLASSIFICATION

EN 14700: T Fe9

DESCRIPTION

- Seamless copper coated tubular wire for semi-automatic gas shielded metal arc hardfacing
- No moisture-pick up with excellent wire feeding properties
- Unique welder appeal
- Manganese steel austenitic deposit which resists combined frictional wear and impacts
- The deposit has the same colour as the base material
- Controlled amount of phosphorus and sulphur elements to ensure excellent mechanical properties

APPLICATIONS

- Rebuilding 14% manganese steel castings
- Repairing railway frogs and crossings

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr
1	14	1	0.5

Structure: austenite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness (3-layer deposit):

As welded: 200 HB

Work hardened: 46 HRC

CONDITIONS OF USE

Current type	Shielding gas	
DC+	EN ISO 14175	M21: Ar + 15 – 25 % CO ₂

Manganese steels must be welded as cold as possible.

OPERATING CONDITIONS

Diameter [mm]	Current [A]	Voltage [V]	Stick-out [mm]
1.2	140-160	24-25	15-20

Recovery: 98 %

WELDING POSITIONS

Flat, half up, half down

PACKAGING

Diameter	1.2 mm	1.6 mm
	EN ISO 544 – ASME II C SFA-5.2 M	
Spool type	BS300	
Weight	15 kg	

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.