

GOLD 320-E, FOR HIGH ALLOY AND MANGANESE STEELS

Description and Application:

Electrode with a high manganese content. **For repair welding on 14 % Mn-steels, welding of dissimilar steels, tool steels, spring steel and for buffer(under) layers** before hard facing

Used in construction and earth moving, tool and die repairs, mining, quarries ,railways etc.

Use for joining and overlaying **of rails and rail points, crusher rotors and cones, anvils, chains, excavator buckets and arms, turbine blades, Drive sprockets** etc

Special Features:

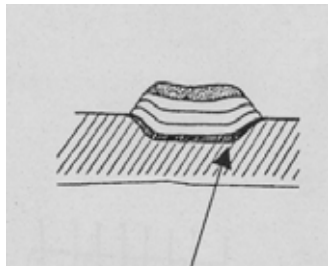
- High impact resistance
- Work-hardens in service
- Tough but machinable.
- Crack resistant (Rm 600-700 MPa)
- High deposition coating
- Weld metal: Cr,Mn,Ni,(Fe base)



Repair earthmoving equipment



Repair rails/ crossings/ends



Buffer layers for hard facing



Rebuild worn crusher rotors and drive sprockets



Mechanical properties Up to:

**Hardness : as welded ~200HB ;
work hardened ~450HB**

Packaging Data

Sizes	2.5x350	3.2x350	4.0x450
Kgs/Packet	4,5	4,5	5,5
Packets/carton	4	4	4
Kgs/carton	18	18	22

Welding instructions	Current (A)	90	130	160
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Welding positions



1G/PA



2F/PB



2G/PC

= + ~ 50V