



## HH 207 MANG CHROME NICKEL MANGANESE AC/DC REVERSE ELECTRODE

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### General Characteristics

HH 207 MANG is a jet type electrode for joining and build-up of various types of alloyed steels. It is very economical due to its high efficiency, with metal recovery of approximately 150%. It is particularly suitable for joining welding of structural steels to high alloy steels, for welding of elastic buffer and intermediate layers when hardsurfacing and for welding austenitic manganese steel. It has excellent mechanical properties, produces finely rippled welds, it is heat resistant, crack resistant, and has easy slag removal. Welds will not spall, and will outwear ordinary hardsurfacing alloys in impact resistance by a large margin.

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### Procedure.

Clean the weld zone free of oil, grease, rust, dirt, etc. Holding the electrode vertically, with a very close arc (torch down). When welding wide hardsurfacing areas, move gently from side to side.

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### Application

HH 207 MANG is used for hard manganese steel as a cushion layer or for joining manganese steel, or joining manganese steel to other alloy steels, for tram rails, railroad rails, switch points, dredger components, heavy equipment, and quarry and construction equipment.

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Tensile Strength	119,000 PSI
Yield Strength	72,000 PSI
Elongation	41%
Hardness (HB) Brinell	Approx. 200
Hardness (HB) Brinell (Work Hardened)	Approx. 520

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Diameter (Inch)	1/8	5/32	3/16
(mm)	3.25	4.0	5.0

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Amps (approx.)	90-150	120-210	165-270
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