

CARVER 9885

FEATURES

Specially formulated low-heat input austenitic stainless-steel electrode. Has excellent heat resistance up to 900°C and is resistant to corrosion by atmosphere, sea water and weak acids.

APPLICATIONS

For joining Austenitic Manganese Steels (12% Mn.) Ideal for joining Austenitic Manganese Steels to Mild Steels, Difficult to weld steels, high alloy steels, etc. Ideal for providing “Elastic Interlayer” - (cushioning layer) before hardfacing. Surfacing manganese steel rails. Repairing cracks in austenitic manganese steel castings.

PROCEDURE

Use either AC or DC, reverse polarity. Clean weld area. Bevel heavy sections to be joined. Generally, on other applications preheating is not necessary. Hold a short arc. Peening will help to relieve stresses. On 14% Mn Steel insure that the weldment temperature is kept below 150°C.

TECHNICAL DATA

Alloy Type	:	Fe, Cr, Ni, Mn Alloy
Tensile Strength	:	620 N/mm ²
Elongation	:	25-35%
Machinability	:	Excellent on all base metals.
Hardness	:	Rockwell C 20-22

RECOMMENDED CURRENT RANGE

SIZE (mm)	2.5	3.15	4.00	5.00
AMPS	50-70	80-110	110-140	150-210

ELECTRODE FOR AUSTENITIC MANGANESE STEELS