



Elgaloy Mix 18

REPAIR & MAINTENANCE

Other

Date: 2015-08-28

Revision: 15

Description:

Elgaloy Mix 18 is a rutile-coated, 160% recovery electrode of the 307 type, intended for joining and building up 13% Mn steels and welding armour plate and difficult-to-weld steels, without the need for preheat. It is also recommended for dissimilar joints between stainless and mild or medium carbon steels. Welds produced with Elgaloy Mix 18 can be stress-relieved without risk of sigma-phase formation and consequent loss of ductility. The deposit work hardens from 200 HV to 450 HV.

Applications:

Buffer layer on 13% Mn steels used in rock crushing and earth moving equipment prior to surfacing with Elgaloy Hard 100, and also rails, rail crossings, frogs etc. without preheat.

Welding positions:



Coating type:

Rutile

Metal recovery:

160%

Redrying temperature:

350 °C, 2h

Hardness:

Hardness as welded:

200 HV

Hardness work hardened:

450 HV

Welding current:

DC+, AC

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min	0,040	0,40	3,30			17,0	9,0
Typical	0,05	0,6	3,6			18,0	9,5
Max	0,14	0,90	4,80	0,035	0,025	20,0	10,0

	Mo
Min	
Typical	<0,3
Max	

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:		475 MPa
Tensile Strength, Rm:		660 MPa
Elongation, A5		40 %

Classification:

EN ISO 3581-A
AWS A5.4

E 18 8 Mn R 53
~E 307-26

Approvals:

Note

AWS: Nearest classification
EN: Deviation in Mn

Product data:

Dim.mm	Product code	Current A		
2,5x350	70402510	70-115		
3,2x350	70403210	90-155		
4,0x450	70404010	130-210		
5,0x450	70405010	160-260		