

ZEDALLOY 16Mn

HARD FACING (High Impact - Work Hardenable)

ALLOY BASIS

C, Mn, Si, Ni

KEY FEATURES:

- Basic type heavy coated electrode
- Modified austenitic Mn steel deposit
- Good machinability
- Crack free and sound weld
- Work hardening characteristics
- Very high resistance to deformation
- Typical 16% Mn deposit
- For superior impact and moderate abrasion resistant overlays
- Recommended buffer layer of Betachrome-N/ND on mild and low alloy steels

APPROVALS: -



TYPICAL APPLICATIONS:

- Bucket teeth, wobblers
- Crusher rollers and jaws
- Pulveriser hammers and beaters
- Austenitic Mn steel rails and casting
- Chain links, Sprockets
- Crusher hammers and mantles
- Suitable for buildup and cushioning on Mn steels and alloy steels





MECHANICAL PROPERTIES OF ALL WELD METAL:

Condition	3 Layer, Hardness, HRc (BHN)
As Welded	16 (200)
Work Hardened	52 (500)

PARAMETERS - PACKING DATA:

Ø x L, mm 3.15 x 350 4.0 x 350 5.0 x 450 6.3 x 450	Amperage, A 100-140 140-180 180-230 230-290	 AC (70 V) / DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Downwards 
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Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kgs each.

Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
			

Physical Properties: With increase in number of squares, property improves