



ZEDALLOY 16Mn

HARD FACING (High Impact - Work Hardenable)



Work hardenable alloy for severe Impact and Moderate Abrasion

ALLOY BASIS :

High Carbon High Manganese with Nickel

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

WELDING POSITION :



AC (70V)/DCEP

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

REDRYING CONDITION : 250-300°C for minimum 1 hr.

PHYSICAL PROPERTIES :

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

Machinability



Abrasion Resistance



Impact Resistance



Corrosion Resistance



PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Carton/Box	Net wt./Box, Kg.
3.15 x 450	100-140	5	4	20
4.0 x 450	140-180	5	4	20
5.0 x 450	180-230	5	4	20
6.3 x 450	230-290	5	4	20

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