

ZEDALLOY 12Mn

HARD FACING (High Impact - Work Hardenable)

ALLOY BASIS

C, Mn, Si

KEY FEATURES:

- Basic type coating
- Easily machinable
- Crack free and sound weld
- Recommended buffer layer of Betachrome-N on mild and low alloy steels
- Typical 12% Mn deposit
- Exhibit excellent work hardening characteristics under severe impact conditions
- Ideal for gouging type abrasion wear



TYPICAL APPLICATIONS:

- Rock crushing jaws
- Cement grinding rings
- Mn steel rails
- Suitable for build-up and cushioning
- Dredger bucket teeth
- Austenitic Mn steel castings
- Hammers
- Crusher mantles

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	Amperage, A	 AC (70 V) / DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Downwards 
3.15 x 350	100-140		
4.0 x 350	140-180		
5.0 x 450	180-230		
6.3 x 450	230-290		

Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kgs each.

Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
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Physical Properties: With increase in number of squares, property improves