

# ZEDALLOY CrMn

**HARD FACING (High Impact - Corrosion Resistance)**

## ALLOY BASIS

C, Mn, Cr

## KEY FEATURES:

- Welding electrode for Austenitic Manganese steels
- Work hardening characteristics Typical 13% Cr deposit
- Specially formulated for resistance against impact, abrasion and corrosion
- Machinable and crack free deposit



## TYPICAL APPLICATIONS:

- Dipper teeth and lips
- Coal mining cutters, Rock crusher
- Pulveriser plows, Pump housing
- Conveyor rolls
- Manganese steel components
- Austenitic Mn steel rails and castings
- Dredger cutter teeth, Buckets
- Ideal for buffer layer before hardfacing on mild, carbon, low alloy and austenitic Mn steels





## MECHANICAL PROPERTIES OF ALL WELD METAL:

Condition	On Carbon Steel HRc (BHN)	On Manganese Steel HRc (BHN)
As Welded	600	20 (220)
As Welded	16 (200)	55 (550)

## PARAMETERS - PACKING DATA:

<b>Ø x L, mm</b> 3.15 x 350 4.0 x 350 5.0 x 450	<b>Amperage, A</b> 90-120	 <b>AC (70 V) /DCEP</b>  <b>REDRYING CONDITION:</b> 300°C for minimum 1 hr.	All Positions, except vertical Downwards  
	130-160		
	170-220		

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