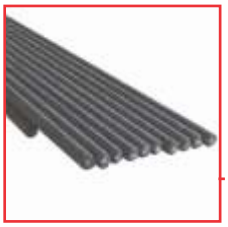

ZEDALLOY CrMn

HARD FACING (Moderate - Abrasion Impact)

Work Hardenable Alloy for Impact – Abrasion – Corrosion Resistance

ALLOY BASIS :

Medium Carbon High Chromium with Manganese

KEY FEATURES :

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

WELDING POSITION :

AC (100 V) / DCEP

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

REDRYING CONDITION : 300°C for 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni
Typical	0.30	15.5	0.7	13	1.0
Specification	0.4 max	14 – 16.5	0.9 max	12 - 14	0.7 – 1.2

PHYSICAL PROPERTIES : Hardness, 3 Layer

Condition	On Carbon Steel HRc (BHN)	On Manganese Steel HRc (BHN)
As Welded	16 (200)	20 (220)
Work Hardened	52 (500)	55 (550)

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 350	90-120	5	4	20
4.0 x 350	130-160	5	4	20
5.0 x 350	170-220	5	4	20

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

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