



ZEDALLOY 12Mn

HARD FACING (High Impact - Work Hardenable)



Work Hardenable Alloy for High Impact Applications

ALLOY BASIS :

High Carbon High Manganese

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

WELDING POSITION :



AC (70V)/DCEP

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

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