



ZEDALLOY 16 Mn

HARD FACING (High Impact - Work Hardenable)

ALLOY BASIS

C, Mn, Si, Ni

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


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





MECHANICAL PROPERTIES OF ALL WELD METAL:

Condition	3 Layer, Hardness, HRc (BHN) Typical
As Welded	16 (200)
Work Hardened	52 (515)

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
3.15 x 450	100-140	 AC (70 OCV) / DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.
4.0 x 450	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 kg each.

Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
			

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