



# 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) Typical
As Welded	16 (200)	16 (200)
Work Hardened	58 (600)	55 (550)

### PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
3.15 x 450	100-130	 AC (70 OCV) /DCEP <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr.
4.0 x 450	140-180	
5.0 x 450	180-220	

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

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