

# ZEDALLOY 12 Mn

**IDENTIFICATION:** Name Printed

## CHARACTERISTICS

An electrode to deposit work hardenable weld metal having typically 12% Mn. The achievable hardness is 200BHN which increase upto 500BHN while exposed to severe impact condition. When using this electrode on Mild steel, Low alloy steel parts, a buffer layer of Betachrome-N is recommended. Weld metal is extremely hard and non-machinable. Ideal for gouging type abrasion wear: Excellent arc stability and low spatter loss. All sizes strike and re-strike easily. Weld beads are smooth, uniform and of excellent appearance.

## TYPICAL APPLICATIONS

For reclamations of Dredger bucket teeth, Rock crushing jaw, Mn steel rails, Rail cross overs, Cement grinding rings, AusteniticMn steel Castings, Crusher mantles, Hammers, etc.

**CURRENT CONDITIONS:** AC (70V), DC (+)

6.3	5.0	4.0	3.2
240-290	180-220	140-180	100-140

## WELDING POSITIONS

F

## REDRYING CONDITIONS

300°C for 1 hour

### WELD METAL CHEMISTRY, (%)

C - 0.65-1.00	S - 0.03 max.
Mn - 12.0-14.0	P - 0.03 max.
Si - 0.60-1.0	

### PACKING DATA

Dia., mm	6.3	5.0	4.0	3.2
Length, mm	450	450	450	450
Wt. per carton, kg	5	5	5	5
Cartons / box	4	4	4	4
Net wt per box, kg	20	20	20	20

### TYPICAL PROPERTIES OF WELD METAL

Weld Metal Hardness 3 Layer Deposit	Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
As Welded 200 BHN (Approx.)	Good	Average	Excellent	Average
Work Hardens to 500 BHN (Approx.)				



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**ADOR WELDING LIMITED**

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