

ZEDALLOY 16 Mn

IDENTIFICATION: Name Printed

CHARACTERISTICS

A heavy-coated electrode depositing modified austenitic manganese steel weld metal. Has soft arc, easily controlled slag and weld bead of smooth regular contour. The weld deposit has superior resistance to impact as it consist of approx. 14% Mn and 3% nickel steel. The hardness of deposited weld metal is about 200 Brinell which increases to approx. 500 Brinell under server impact in service. When using on mild steel, low-alloy steel parts of buffer layer of BETACHROME -N/ND - must be given.

TYPICAL APPLICATIONS

- Austenitic manganese steel parts such as stone crusher jaws
- Dredger bucket teeth
- Hammers of grinding mill.
- Manganese steel rail
- For repairing and building up austenitic manganese steel casting in foundries.

CURRENT CONDITIONS : AC (70) or DC (+)

6.3	5.0	4.0	3.2
240-290	180-220	140-180	100-120

WELDING POSITIONS

F

REDRYING CONDITIONS

300°C for 1 hour

WELD METAL CHEMISTRY (%)

C - 0.50-0.80	Ni - 3.00-4.00
Si - 0.80 max	S - 0.03 max
Mn - 13.00 -15.00	P - 0.03max.

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 Layers.	Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
AW 200 BHN (Approx.)	Good	Average	Excellent	Average
Work Hardened 500 BHN (Approx.)				



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

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