



SUBARC ZERON 100X

Sub Arc Zeron X is a solid electrode for welding Zeron 100 and other super duplex alloys for service in the as welded condition. This electrode is overmatching with respect to nickel content to achieve the correct austenite-ferrite micro structural phase balance.

CLASSIFICATIONS

BS EN S2594NL

CHEMICAL ANALYSIS (TYPICAL)

% Carbon	0.015	% Nickel	9.30
% Manganese	0.70	% Molybdenum	3.70
% Silicone	0.40	% Tungsten	0.60
% Sulphur	0.002	% Copper	0.70
% Phosphorous	0.020	% Nitrogen	0.23
% Chromium	25.00	PRE _N 41	PRE _w 42
Pitting Resistance Equivalent PRN _n = Cr+3.3Mo+ 16N		PRN _w Cr+3.3Mo+ 1.65W+ 16N	

**TYPICAL MECHANICAL PROPERTIES
(ALL WELD METAL IN THE AS WELDED
CONDITION)**

0.2% Proof Stress	700 - 750 MPa
Tensile Strength	890 - 950 MPa
Elongation on 5d	24%
Charpy V-Notch -50°C	40J
Hardness HV	290

* Flux Dependant

PACKING DATA

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
2.4	350	29	078-502	25

Recommended Flux Metrode SSB

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