

TIG ZERON 100X



TIG 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 W 2594 NL

CHEMICAL ANALYSIS

% 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 at -50°C	130J
Hardness HV	290

PACKING DATA

(DC -)

Diameter (mm)	Amps	Volts	Item Number	Pack Mass (Kg)
1.6	100	12	078-100	2.5
2.4	100	12	078-102	2.5

Recommended Shielding Gas Argon

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