

**ZERON 100XKS**



Zeron XKS is a basic all-position 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. It is designed for the most demanding vertical and overhead welding positions such as fixed pipework qualified to ASME 6G position.

**CLASSIFICATIONS**

BS EN E2594 LB 42

**CHEMICAL ANALYSIS**

% Carbon	0.03	% Nickel	9.30
% Manganese	0.90	% Molybdenum	3.60
% Silicone	0.50	% Tungsten	0.70
% Sulphur	0.005	% Copper	0.70
% Phosphorous	0.020	% Nitrogen	0.23
% Chromium	25.00	<b>PRE<sub>N</sub> 41</b>	<b>PRE<sub>w</sub> 42</b>
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	650 - 750 MPa
Tensile Strength	850 - 950 MPa
% Elongation on 5D	22 - 25%
Charpy V-Notch at -20°C	55J
Charpy V-Notch at -50°C	40J
Hardness HV	270 - 320

**PACKING DATA**

(DC +)

Diameter (mm)	Electrode Length (mm)	Current Amps	Item Number	Pack Mass (Kg)
2.5	300	50 - 75	078-372	3 x 4
3.2	350	70 - 95	078-373	3 x 4.7
4.0	350	100 - 155	078-374	3 x 4.5

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