

Zeron™ 100XKS

TOP FEATURES

- Basic pipe-welding MMA electrode for superduplex steels
- Designed for the most demanding vertical and overhead welding positions
- High moisture resistance
- Recovery is about 105%

TYPICAL APPLICATIONS

- Oil and gas production
- Mining, chemical and pharmaceutical industries

CLASSIFICATION

AWS A5.4 E2595-15
EN ISO 3581-A E 25 9 4 N L B 4 2

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

ABS	DNV
+	+

CHEMICAL COMPOSITION (WEIGHT %), WELD METAL

	C	Mn	Si	S	P	Cr	Ni	Mo	W	Cu	N	PREN	PREW
Min.	not specified	not specified	not specified	not specified	not specified	24.0	9.0	3.5	0.5	0.5	0.2	40	40
Max.	0.03	1.0	1.0	0.01	0.03	26.0	10.0	4.0	1.0	1.0	0.3	45	45
Typical	0.025	0.9	0.5	0.005	0.02	25	9.3	3.6	0.7	0.7	0.23	42	43

Pitting resistance equivalent PREN = Cr + 3.3Mo + 16N

Pitting resistance equivalent PREW = Cr + 3.3Mo + 1.65W + 16N

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

As welded	Min.	Typical
Tensile strength (MPa)	760	800-950
0.2% Proof strength (MPa)	550	650-750
Elongation (%)	4d	30
	5d	22-27
Reduction of area (%)	not specified	40-45
Impact ISO-V (J)	- 20°C	> 55
	- 50°C	> 40
Hardness (HV)	not specified	270-320

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	50-70
3.2 x 350	65-100
4.0 x 350	90-140

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	CAN	197	3.4	Z100XKS-25-1
3.2 x 350	CAN	120	4.1	Z100XKS-32-1
4.0 x 350	CAN	80	4.1	Z100XKS-40-1

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.