

# 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 %), TYPICAL, ALL WELD METAL

	C	Mn	Si	S	P	Cr	Ni	Mo	W	Cu	N	PREN
Min.	not specified	not specified	not specified	not specified	not specified	24.0	9.0	3.5	0.5	0.5	0.2	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
Typical	0.025	0.9	0.5	0.005	0.02	25	9.3	3.6	0.7	0.7	0.23	43

Pitting resistance equivalent Number PREN = 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	%	15	30
Elongation 5d	%	20	22-27
Reduction of area	%	not specified	40-45
Impact ISO-V - 20°C	J	not specified	> 55
Impact ISO-V - 50°C	J	not specified	> 40
Hardness	HV	not specified	270-320

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
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
3.2 x 350	VPMD	58	2.0	Z100XKS-32-2
4.0 x 350	VPMD	40	2.0	Z100XKS-40-2

## 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](http://www.lincolnelectric.eu) for any updated information.