

# Zeron™ 100X MIG

## TOP FEATURES

- Designed for strength and resistance to corrosion
- For welding of 25%Cr super duplex stainless steels
- Matching the proprietary Zeron 100 alloy
- Also used for joining supermartensitic stainless steels
- Superior resistance to stress corrosion cracking (SCC) and pitting corrosion

## CLASSIFICATION

AWS A5.9 ER2594  
EN ISO 14343-A G 25 9 4 N L

## SHIELDING GASES (ACC. EN ISO 14175)

I3 Inert gas Ar+ 0.5-95% He

## APPROVALS

ABS	TÜV
+	+

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

	C	Mn	Si	S	P	Cr	Ni	Mo	W	Cu	N	PREN
Typical	0.015	0.7	0.35	0.002	0.02	26	9.3	3.85	0.6	0.6	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	860
0.2% Proof strength	Mpa	550	645
Elongation 4d	%	15	25
Elongation 5d	%	20	23
Reduction of area	%	-	28
Impact ISO-V -50°C	J	-	60
Hardness, cap/mid	HV	-	290

- = not specified

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.0	SPOOL (S300)	12.5	MZ100X-10
1.2	SPOOL (S300)	12.5	MZ100X-12

## 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.