

Shielded Metal Arc Welding (SMAW – Stick)

Hardfacing for **extreme abrasion** even when accompanied with impact.

Features

- Unique Tubular Design
- Low Heat Requirements
- Fast Deposition Rates Rival the Speed of Wire Feed
- Hardness: 58 – 62RC
- Resists Severe Abrasion
- Ultra High Alloy Content of 38%.
- Little Waste
- Super fast deposit rates up to 10 lb/hr.
- Flux coating impervious to atmosphere – No Need for Special Storage

Characteristics

Zeta C is the ultimate hardfacing rod for extreme abrasion. Deposits have an incredible first pass hardness, the highest weld metal deposit per pound of electrode (over 50% more than conventional rods), and the fastest deposition rates (twice as fast as conventional rods). These properties make Zeta C the most cost effective hardfacing rod available.

Zeta C is proven on many applications including; Pump Castings & Impellers, Crushing Equipment, Brick Manufacturing Equipment, Suction Dredge Cutters, Railway Ballast Tampers, Dragline Buckets and Teeth, Earth Moving Equipment, Power Shovels, Augers, Clam Shell Buckets, Rolling Mill Guides, Agricultural Implements, Sizing Screens, Dredge Buckets & Lips, and Cast Iron.

Technical

Size and Amps AC/DC $\pm 40\%$

Inches	1/4	3/8	1/2
(mm)	(6.4)	(9.5)	12.7)
Amps	100	180	225

With DC use reverse polarity. (DCEP)

Application

- Weld downward or with slight uphill slope for heavier build-up.
- Remove scale, rust or fatigued metal before welding.
- Preheat thick or alloy steels, except 11-14% manganese steels must be cool during welding.
- Stress relief cracks are expected and deposits should be limited to two layers.

Zeta[®] B

Shielded Metal Arc Welding (SMAW – Stick)

Hardfacing for abrasion resistance **when accompanied by moderate to heavy impact.**

Features

- Unique Tubular Design
- Low Heat Requirements
- Fast Deposition Rates Rival the Speed of Wire Feed
- Hardness: 50 – 55 RC
- High Alloy Content of 33%.
- Super fast deposit rates up to 10 lb/hr.
- Flux coating impervious to atmosphere – No Need for Special Storage

Characteristics

In many hardfacing applications, abrasion is accompanied by moderate to heavy impact. **Zeta B** has incredibly high resistance to abrasion, and also has the ability to withstand impact without chunking off. In applications with high abrasion coupled with lower impact then **Zeta C** is the ideal choice, but where abrasion *and* moderate to heavy impact exists then **Zeta B** is the ideal choice.

Zeta B has all of the speed and efficiency benefits of Zeta C, making it an incredibly cost effective hardfacing alloy.

Zeta B proven applications; Excavator Buckets & Teeth, Striker Bars, Dozer End Plates, Shovel Teeth & Burden Areas, Grizzlys, Mill Hammers, Dragline Buckets, and Ball Mill Liner Plates.

Technical

Size and Amps AC/DC ±40%

Inches	1/4	3/8	1/2
(mm)	(6.4)	(9.5)	12.7)
Amps	100	180	225

With DC use reverse polarity. (DCEP)

Application

- Weld downward or with slight uphill slope for heavier build-up.
- Remove scale, rust or fatigued metal before welding.
- Preheat thick or alloy steels, except 11-14% manganese steels must be cool during welding.
- Stress relief cracks are normal and deposits are best limited to two layers.