ZETA® - B

Shielded Metal Arc Welding
(SMAW-Stick)
For hardfacing to resist abrasion
with moderate impact

ZETA® - C

Shielded Metal Arc Welding
(SMAW-Stick)
For hardfacing extreme abrasion
with some impact

CHARACTERISTICS

ZETA-B deposits have been developed to resist abrasion along with moderate to heavy impact. Deposits outlast other materials because: alloy content of 33%, Cr, Mn and C produce fine chrome carbides in an austentic iron matrix. Resultant hardness is 50-55RC with super hard carbides.

ZETA-B Proven Applications: Excavator Buckets & Teeth - Striker Bars - Feeder Screws - Dozer End Plates - Shovel Teeth & Burden Areas - Grizzleys - Mill Hammers - Post Hole Augers - Clam Shell Buckets - Dragline Buckets - Ball Mill Liner Plates - Ripper Shanks and Boots.

ZETA-C deposits are even more sophisticated and have proven to be outstanding for severe abrasion from coarse or fine particals even when accompanied by impact. This most versatile alloy contains 38% Cr, Mo, Vn, Mn, and C which produces chrome carbides in an austentic martensitic iron matrix. Resultant hardness is 58-62RC with refined ultra carbides.

ZETA-C Proven Applications: Pump Castings & Impellers - Brick Manufacturing Equipment - Crushing 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 - Grizzleys - Sizing Screens - Dredge Buckets & Lips - Cast Iron.

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.

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)