

ZETA® - FLUX CORE

Flux Core Arc Welding
(FCAW - Gas Required)

For hardfacing carbon and alloy steels. Abrasion and heavy impact resistance.

FEATURES

- Extremely tough deposit
- Deposit hardness 55-60 RC
- Resists heavy impact
- High chrome and silicone carbide
- Corrosion resistant
- Excellent running characteristics
- Rapid deposition

CHARACTERISTICS

ZETA FLUX CORE is a gas shielded flux core wire that gives superior resistance to wear in high abrasion situations, even when combined with heavy impact loads. The unique and very high alloy content provides exceptionally dense semi-austenitic deposits.

ZETA FLUX CORE is very easy to run, especially in vertical wear facing applications, and will greatly extend the service life on a wide range of equipment and machinery.

5

APPLICATION

ZETA FLUX CORE will give excellent results on a wide range of hardfacing applications, even with the high corrosion mediums. The high chrome deposits resist stress cracking. Applications include dredge cutter teeth, conveyer screws, bulldozer blades, pump housing and dipper teeth.

APPROXIMATE SETTINGS: DCEP (reverse polarity)

WIRE DIAMETER	VOLTS	AMPS	STICK OUT
.045"(1.2mm)	21-26	150-250	1/2"
1/16"(1.6mm)	23-28	250-350	3/4"

SHIELDING GAS OPTIONS:

100% CO₂

75% Argon - 25% CO₂