



Zerock E55L Stainless Steel Electrodes

◆ **Description:**

Superior all purpose stainless steel austenitic type electrode. Suitable for dissimilar metal with high tensile strength. Excellent to corrosion resistance, good for joining shafting materials and unknown composition steel. Zerock E55L designed for heat and crack resistance.

◆ **Applications:**

Can be used for overlaying and joining dissimilar steels to one another, high and low carbon steels, spring steels, tool and die steel, cast steels and steels of unknown composition.

◆ **Classification:**

AWS E312L-16

◆ **Typical Chemical Composition of Deposited Metal (%):**

<u>C</u>	<u>Mn</u>	<u>Si</u>	<u>S</u>	<u>P</u>	<u>Cr</u>	<u>Ni</u>	<u>Mo</u>	<u>Cu</u>
0.030	1.27	0.72	0.005	0.026	29.99	9.26	0.10	0.03

◆ **Mechanical Properties of Deposited Metal:**

Tensile Strength	840 Mpa
Elongation	30%
Hardness	21HRC

◆ **Type of Current:**

AC or DC

◆ **Amperages Setting:**

2.5mm	50 – 90
3.2mm	100 - 130
4.0mm	130 – 160