SUPER ZEDALLOY

IDENTIFICATION: Name Printed

CHARACTERISTICS

An electrode to deposit weld metal having 35%Cr and 3.5%C and can be used where resistant to severe abrasion is necessary about 1000°C. The achievable hardness is 600BHN typically. Use only one or two layers to avoid cracking. All sizes strike and re-strike easily. Weld beads are smooth, uniform and of excellent appearance.

CURRENT CONDITIONS: AC, DC (+)

5.0	4.0	3.2
160-200	120-160	90-120

WELDING POSITIONS

F

REDRYING CONDITIONS

300°C for 1 hour

TYPICAL APPLICATIONS

For usage in Ceramic industries. For reclamations of Plough shares, Cultivator shovels, Coke chutes, Sand blasting equipments, Conveyors, Screws, Grinding rings, Edge runner scrappers, Parts of earth moving and mining equipments, etc.

WELD METAL CHEMISTRY, (%)			
C	- 3.5-4.5	S	- 0.03 max.
Mn	- 0.8-1.3	P	- 0.03 max.
Si	- 0.60-0.90	Cr	- 33.0-36.0

PACKING DATA			
Dia., mm	5.0	4.0	3.2
Length, mm	350	350	350
Wt. per carton, kg	5	5	5
Cartons / box	4	4	4
Net wt per box, kg	20	20	20

TYPICAL PROPERTIES OF WELD METAL

Weld Metal Hardness 3 Layer Deposit	Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
As Welded 600 BHN (Approx.)	Non Machinable	Excellent, even for temp upto 1000°C	Poor	Good