ZEDALLOY 20 Cr

IDENTIFICATION: Name Printed

CHARACTERISTICS

An electrode to deposit work hardenable weld metal having typically 20% Cr. The weld metal is semi Austenitic and has hardness of ~200BHN which increase upto 400BHN on peening and to ~550BHN while exposed to severe impact condition. Excellent arc stability and low spatter loss. 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
180-220	140-180	100-140

WELDING POSITIONS

F

REDRYING CONDITIONS

300^{0}C for 1 hour

TYPICAL APPLICATIONS

For reclamations of Dipper teeth, Shovel tracks, Rock crushers, Coal mining cutters, charging rams, Tractor gousers, Pump housi ng, Conveyor rolls, Conveyor buckets, Crusher mantles, Screw flights, Truck chains, Mill hammers, Scrapper blades, Dredger cutter teeth, Pulveriser plaws, Sand pump impellers, Ingot tongs, etc.

WELD METAL CHEMISTRY, (%)

C	- 0.25 max.	S	- 0.03 max.	Ni	- 4.0-5.0
Mn	- 2.5-3.5	P	- 0.03 max.		
Si	- 0.20-0.50	Cr	- 17.0-20.0		

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 250 BHN (Approx.)	Good	Average	Excellent	Good
Work Hardened after peening - 400 BHN Severe Impact - 550 BHN (Approx.)				

WELDERS TO THE NATION SINCE 1951

ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

www.adorwelding.com