

# ZEDALLOY 250

## CHARACTERISTICS

An electrode to deposit air hardening type of weld metal having hardness in the range of 240-260 BHN approx. Weld metal is machinable. A buffer layer of Tenalloy - 16 is recommended on hard base materials. The electrodes have excellent arc stability, low spatter loss and re-striking properties. Weld beads arc smooth, uniform and of excellent appearance.

## TYPICAL APPLICATIONS

For reclamations of gears, pinion teeth, tram tyers, pulleys, shafts, couplings, sugarcane crushers, spindles, gear wheels, hammers, axels etc.

## CURRENT CONDITIONS: AC / DC (-)

5.0	4.0	3.2
180-220	140-180	100-140

## REDRYING CONDITIONS

110°C for 1/2 hr.

## WELDING POSITIONS : F

### WELD METAL CHEMISTRY, (%)

C	-	0.20 max.	Mn	-	0.15-0.40	Si	-	0.25 max.
S	-	0.03 max.	P	-	0.03 max.	Cr	-	0.90-1.20

### PACKING DATA

Dia., mm	5.0	4.0	3.2
Length, mm	450	450	450
Wt. per carton, kg	5	5	5
Cartons / box	4	4	4
Net wt per box, kg	20	20	20

### PHYSICAL PROPERTIES

Hardness (3 layer deposit)	Machinability	Abrasion Resistance	Impact Resistance
240 - 260 BHN (As welded)	Good	Good	Average



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**ADOR WELDING LIMITED**

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