

# ZEDALLOY 350 ( LH )

**IDENTIFICATION:** Name Printed

**CURRENT CONDITIONS:** AC, DC (+)

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

## CHARACTERISTICS

A hydrogen controlled electrode to deposit air hardening type of weld metal having the hardness in the range of 340-360 BHN approx. Weld metal is machinable with carbide tools. A buffer layer of Tenalloy-16 is recommended on hard base materials. Excellent arc stability and low spatter loss. All sizes strike and re-strike easily. Weld beads are smooth, uniform and of excellent appearance.

## WELDING POSITIONS

F

## REDRYING CONDITIONS

300°C for 1 hour

## TYPICAL APPLICATIONS

For reclamations of Conveyor parts, Cog wheels, Cams, Cold punching dies, Brake shoes, Drive sprockets, Gear shaft, Latch bars and plates, Plough shares, Pulleys, Shafts, Couplings, Steel castings, Shear blades, Wobbler ends, Axles, etc.

### WELD METAL CHEMISTRY, (%)

C - 0.08-0.15	S - 0.03 max.
Mn - 0.60-1.00	P - 0.03 max.
Si - 0.45-0.70	Cr - 2.50-3.50

### 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

### TYPICAL PROPERTIES OF WELD METAL

Weld Metal Hardness 3 Layer Deposit	Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
As Welded 340-360 BHN	Highly suitable with Carbide Tools	Excellent	Good	N.A.



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**ADOR WELDING LIMITED**

(Formerly Known as Advani-Oerlikon Ltd.)

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