

ZEDALLOY 350

IDENTIFICATION: Name Printed

CHARACTERISTICS

An electrode to deposit air hardening type of weld metal having hardness in the range of 330-380 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.

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.

APPROVALS RDSO - H4B

CURRENT CONDITIONS: AC, DC (-)

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

WELDING POSITIONS

F

REDRYING CONDITIONS

110°C for 1/2 hour

WELD METAL CHEMISTRY, (%)

C - 0.30 max.	S - 0.03 max.
Mn - 0.40-0.70	P - 0.03 max.
Si - 0.20-0.40	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 330-380BHN	Good, only with Carbide Tools	Excellent	Good	N.A.



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

www.adorwelding.com

