

ZEDALLOY 500

IDENTIFICATION: Name Printed

CHARACTERISTICS

A heavy coted, rutile type hardfacing electrode giving smooth arc, medium penetration, low spatter and easily detachable slag. The electrode deposit air-hardening type weld metal is surface-finished by grinding. The weld metal can withstand atmospheric corrosion and suitable applications in the areas involving high stress abrasion at room temperature, medium impact and resistance to metal-to-metal wear. An appreciable increase in the impact resistance occurs after tempering.

TYPICAL APPLICATIONS

- Shear blades
- Cutting tools
- forming dies
- ingot-tongs
- Crane wheel etc.

WELD METAL CHEMISTRY (%)

C - 0.30 - 0.60 Cr - 5.0 - 9.0 S - 0.030 max
Mn - 0.60 - 1.0 Mo - 0.50 max P - 0.030 max
Si - 0.50 max V - 0.50 max

TYPICAL PROPERTIES OF WELD METAL

Weld Metal Hardness 3 Layer Deposit	Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
AW 450 - 550 BHN	Non - machinable	Excellent	Good	N.A.

CURRENT CONDITIONS : AC (70) or DC (+)

5.0 4.0 3.2
180-240 130-170 100-120

WELDING POSITIONS

F

REDRYING CONDITIONS

110⁰C for 1/2 hour

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



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

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