

# ZEDALLOY 550 ( LH )

**IDENTIFICATION:** Name Printed

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

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

## CHARACTERISTICS

A hydrogen controlled, iron powder electrode to deposit weld metal having the hardness in the range of 540-590 BHN approx. Weld metal is non-machinable. A buffer layer of Tenalloy-16 is recommended on hard base materials. It can withstand heavy abrasion, friction and moderate impact. 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 Cane cutting knives, Bamboo chipper knives, Dis-integrator hammers, Crane wheels, Shear blades, Metal cutting and forming tools, Punches, dies, drilling bits, Shears, Oil expeller worms, Crushers, Hammers, Mine rails, Caterpillar treads, Conveyor parts etc..

### WELD METAL CHEMISTRY, (%)

C - 0.40-0.65	Mo - 0.70-1.10
Mn - 0.50-0.70	V - 0.40-0.80
Si - 0.60-1.0	Cr - 6.5-7.80
S - 0.03 max.	P - 0.03 max.

### 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 540-590BHN (Approx.)	Non machinable / only grinding	Excellent	Good	N.A.



WELDERS TO THE NATION SINCE 1951  
**ADOR WELDING LIMITED**

(Formerly Known as Advani-Oerlikon Ltd.)

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