

ZEDALLOY 550

IDENTIFICATION: Name Printed

CURRENT CONDITIONS: AC, DC (-)

5.0 4.0 3.2
180-220 140-180 100-120

CHARACTERISTICS

An electrode to deposit air hardening type of weld metal having the hardness in the range of 540-580 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 excellent appearance.

WELDING POSITIONS

F

REDRYING CONDITIONS

110°C for 1 hour

TYPICAL APPLICATIONS

For reclamations of Cone 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 - 0.40-0.70	Mo - 0.50-0.80
Mn - 0.20-0.40	V - 0.40-0.70
Si - 0.20-0.45	Cr - 6.0-7.80

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 540-580 BHN (Approx.)	Non machinable	Excellent	Good	N.A.



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

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