

ZEDALLOY 600

IDENTIFICATION: Name Printed

CHARACTERISTICS

A heavy coated, hydrogen controlled basic type, iron powder electrode giving a smooth arc, medium penetration and least spatter Slag easily detachable. The weld deposit is extremely hard sound and non-machinable. The hydrogen controlled basic type coating enables the electrode to be used on high carbon and high sulphur steels without giving underbead cracking or porosity. The weld deposit can be finished by grinding. It gives approximately 58RC (600 Brinell) hardness on single layer weld deposit.

TYPICAL APPLICATIONS

For reclamations of Sugarcane cutting knives, Bamboo chipper knives, Paper cutting 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.

CURRENT CONDITIONS: AC (70V), DC (+)

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

WELDING POSITIONS

F

REDRYING CONDITIONS

300°C for 1 hour

WELD METAL CHEMISTRY, (%)

C - 0.40-0.65	Mo - 0.70-1.10
Mn - 0.80-1.40	V - 0.35-0.55
Si - 1.2-1.70	Cr - 7.50-9.00
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 one Layer Deposit	Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
As Welded 600 BHN (Approx.)	Non machinable / only grinding	Good	Good	Moderate



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

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