SUPER ZEDALLOY Ni

CLASSIFICATIONS
COATING TYPE: Basic

COATING FACTOR: Heavy IDENTIFICATION: Brand Printed

CURRENT CONDITIONS : AC, DC (+)

5.0	4.0	3.2
160-200	120-160	90-120

CHARACTERISTICS
A super-heavy-coated electrode for hardfacing applications on mild steel, carbon steels and low-alloy steels where resistance to severe abrasion especially at elevated temperature is necessary. The weld metal composition is approx. 30% Cr, 5% Ni, 4% Si and 3.0% Carbon. The deposit has a Brinell hardness of approx. 545 (55Rc) at room temperature and approx. 350 Brinell at 500°C. It has a very quiet and stable arc. The weld deposit retains hardness at relatively high temperatures. Use only one or two layers to avoid cracking. KEEP DRY.

WELDING POSITIONS
F
REDRYING CONDITIONS
300°C for 1 hour

TYPICAL APPLICATIONS
For usage in blast furnance bells and hoppers. Steel mill equipments, Metallurgical industry and chemical plants etc

TYPICAL PROPERTIES OF WELD METAL

Weld Metal Hardness 3 Layer Deposit	Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
As Welded 500 BHN	only by grinding	Excellent, even at elevated temparatures	Poor	Good
AT 500°C , 350 BHN				

WELD METAL CHEMISTRY, wt%

C - 2.4-3.2	S - 0.03 max.	Ni - 4.5-6.0
Mn - 1.7-2.7	P - 0.03 max.	
Si - 3.8-5.2	Cr - 27.0-30.0	

PACKING DATA

Dia., mm	5.0	4.0	3.2
Length, mm	350	350	350
Wt. per carton, kgs	5.25	5.25	5.25
Cartons/ box	4	4	4
Wt. per box, kgs	21	21	21