



ZEDALLOY 20Cr

CLASSIFICATIONS

COATING TYPE: Basic

COATING FACTOR: Heavy

IDENTIFICATION: Brand Printed

CURRENT CONDITIONS: AC, DC (+)

6.3	5.0	4.0	3.2
240	180-	140-	100-
290	220	180	140

CHARACTERISTICS

An electrode to deposit work hardenable weld metal having typically 20% Cr. The weld metal is semi Austenitic and has hardness of ~250BHN which increase upto 400BHN on peening and to ~500BHN while exposed to severe impact condition. 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 Dipper teeth, Shovel tracks, Rock crushers, Coal mining cutters, charging rams, Tractor gousers, Pump housing, Conveyor rolls, Conveyor buckets, Crusher mantles, Screw flights, Truck chains, Mill hammers, Scrapper blades, Dredger cutter teeth, Pulveriser plaws, Sand pump impellers, Ingot tongs, etc.

TYPICAL PROPERTIES OF WELD METAL				
Weld Metal Hardness 3 Layer Deposit	Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
As Welded 250 BHN	Good	Average	Excellent	Good
Work Hardened after peeng - 400 BHN				
Severe Impact - 550 BHN				

WELD METAL CHEMISTRY, wt%		
C - 0.25 max.	S - 0.03 max.	Ni - 4.0-5.0
Mn - 2.5-3.5	P - 0.03 max.	
Si - 0.20-0.50	Cr - 17.0-20.0	

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