



ZEDALLOY 350 (LH)

CLASSIFICATIONS

COATING TYPE: Basic COATING FACTOR: Heavy
 IDENTIFICATION: Brand Printed

CURRENT CONDITIONS: AC, DC (+)
 5.0 4.0 3.2
 180- 140- 100-
 220 180 140

CHARACTERISTICS

A hydrogen controlled electrode to deposit air hardening type of weld metal having typically 350BHN hardness. Weld metal is machinable with carbide tools. A buffer layer of Tenalloy-16 is recommended on hard base materials. 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 Conveyor parts, Cog wheels, Cams, Cold punching dies, Brake shoes, Drive sprockets, Gear shaft, Latch bars and plates, Plough shares, Pulleys, Shafts, Couplings, Steel castings, Shear blades, Wobbler ends, Axles etc.

TYPICAL PROPERTIES OF WELD METAL				
Weld Metal Hardness 3 Layer Deposit	Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
As Welded 350 BHN	Good, only with Carbide Tools	Excellent	Good	N.A.
Work Hardened N.A.				

WELD METAL CHEMISTRY, wt%	
C - 0.08-0.15	S - 0.03 max.
Mn - 0.60-1.00	P - 0.03 max.
Si - 0.45-0.70	Cr - 2.50-3.50

PACKING DATA			
Dia, mm	5.0	4.0	3.2
Length, mm	450	450	450
Wt. per carton, kgs	5.25	5.25	5.25
Cartons/ box	4	4	4
Wt. per box, kgs	21	21	21

Related Products : Automelt Gr. A wire + Automelt H35 flux