



ZEDALLOY 550 (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, iron powder electrode to deposit weld metal having typically 550BHN hardness. 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 of excellent appearance.

WELDING POSITIONS

F

REDRYING CONDITIONS

300°C for 1 hour

TYPICAL APPLICATIONS

For reclamations of Cane 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..

TYPICAL PROPERTIES OF WELD METAL				
Weld Metal Hardness 3 Layer Deposit	Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
As Welded 550 BHN	Non machinable / only grinding	Excellent	Good	N.A.
Work Hardened N.A.				

WELD METAL CHEMISTRY, wt%			
C - 0.40-0.65	Mo - 0.70-1.10		
Mn - 0.50-0.70	V - 0.40-0.80		
Si - 0.60-1.0	Cr - 6.5-7.80		

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 GrA wire + Automelt H55 flux