



# ZEDALLOY 600

## CLASSIFICATIONS

COATING TYPE: Basic

COATING FACTOR: Heavy

IDENTIFICATION : Brand Printed

CURRENT CONDITIONS: AC, DC (+)

## 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, which could go upto 60RC after suitable heat treatment.

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

## WELDING POSITIONS

F

## REDRYING CONDITIONS

300°C for 1 hour

## 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.

TYPICAL PROPERTIES OF WELD METAL				
Weld Metal Hardness 3 Layer Deposit	Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
As Welded 600 BHN	Non machinable / only grinding	Good	Good	Moderate
offer heat treatment 650 BHN				

WELD METAL CHEMISTRY, wt%	
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

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