



ZEDALLOY K

COATING TYPE: Basic

COATING FACTOR: Heavy IDENTIFICATION: Brand Printed

CURRENT CONDITIONS: AC, DC (+)

5.0	4.0	3.2	2.5
180-	140-	100-	60-
200	180	130	80

CHARACTERISTICS

An electrode to deposit air hardenable type weld metal having approx. 600BHN hardness. The weld metal is metallurgically balanced to obtain optimum resistance to metal-to-metal wear, abrasion and impact. When used on hardenable steels suitable preheating should be done. 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 usage on Hog and chipper knives, Blanking dies, Forming dies, Cams skelp hooks, Cutting tools, Shear blades, Mining tools, Ingot fitting tongs, Rolling mill guides, Wood working tools 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	Excellent	Excellent	Good
Work Hardened - 650 BHN				

WELD METAL CHEMISTRY, wt%	
C - 0.50-0.80	S - 0.03 max.
Mn - 0.40-0.70	P - 0.03 max.
Si - 0.30-0.70	Cr - 4.0-5.0
Mo - 8.0-9.0	W - 0.90-1.10
V - 0.70-0.90	

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