



## ZEDALLOY 250

**HARD FACING (Moderate - Abrasion Impact)**



Hardfacing Electrode for moderate Abrasion - Impact Condition

### ALLOY BASIS :

Low Carbon Low Chromium

### KEY FEATURES :

- Rutile coated electrode
- Weld deposit resistant to moderate and impact
- Air hardenable machinable deposit
- Good resistance against rolling and sliding friction
- Recommended buffer layer of Tenalloy-16 on hard base materials

### WELDING POSITION :



AC (80 V) / DCEN

### TYPICAL APPLICATIONS :

- Gears, Pinion teeth
- Track links, Tram tyres
- Sugarcane crushers
- Gear wheels, Hammers
- Wobblers, Chassis
- Rollers, Sprockets
- Pulleys, Shafts
- Couplings, Spindles
- Excavators, Axles
- Rail points and crossings

**REDRYING CONDITION : 110°C for ½ hr.**

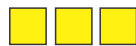
### PHYSICAL PROPERTIES :

Condition	Hardness, 3 Layer HRc (BHN)
As Welded	23-27 (240-260)

### Machinability



### Abrasion Resistance



### Impact Resistance



### Corrosion Resistance



### PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Carton/Box	Net wt./Box, Kg.
3.15 x 450	100-140	5	4	20
4.0 x 450	140-180	5	4	20
5.0 x 450	180-220	5	4	20

*Physical Properties: With increase in number of squares, property improves*