



ZEDALLOY 400B

HARD FACING (Build Up)



Hardfacing Electrode for High Wear and Impact Application

ALLOY BASIS :

Low Carbon Low Chromium

KEY FEATURES :

- Basic type heavy coating
- Possible to deposit heavy build up without the need of buffer layers
- Machining only with sintered hard metal tipped tools
- Highly wear resistant overlays can withstand impact & shock
- Recommended buffer layer of Betachrome -N/ND on crack sensitive steels

WELDING POSITION :



AC (70 V) / DCEP

TYPICAL APPLICATIONS :

- Rebuilding rail crossing and switch points, Wheel flanges
- Wear parts of Dredgers
- Striking tools, Dies, Tyres
- Slide surfaces subjected to heavy wear
- Polygon edges, Bearing surfaces
- Lower dies & punches

REDRYING CONDITION :

250-300°C for minimum 1 hr.

REBAKING CONDITION :

300-350°C for 2 hrs.

PHYSICAL PROPERTIES :

Condition	Hardness, 3 Layer HRc (BHN)
As Welded	40-45 (370-420)

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 350	100-135	5	4	20
4.0 x 350	120-180	5	4	20
5.0 x 350	170-240	5	4	20

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