



ZEDALLOY 550

HARD FACING (Moderate - Abrasion Impact)



Hardfacing Electrode for Resistance against High Abrasion and Moderate Impact

ALLOY BASIS :

Medium Carbon High Chromium

KEY FEATURES :

- Rutile coated electrode
- Air hardenable deposit
- Non machinable
- Resistant to spalling and cracking
- Resistance against high stress abrasion and friction
- Can withstand moderate impact
- Recommended buffer layer of Tenalloy-16 on hard base materials

WELDING POSITION :



AC (80 V) / DCEN

TYPICAL APPLICATIONS :

- Dis-integrator hammers
- Excavator teeth, Shear blades
- Bulldozer blades, Bucket lip
- Metal cutting and forming tools
- Crane wheels, Caterpillar treads
- Cane cutting knives

REDRYING CONDITION : 110°C for 1 hr.

PHYSICAL PROPERTIES :

Condition	Hardness, 3 layer HRc (BHN)
As Welded	54-56 (540-580)

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	100-130	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