



ZEDALLOY 600B

HARD FACING (Moderate - Abrasion Impact)



Hardfacing Electrode for Extreme Abrasion and Friction

ALLOY BASIS :

Medium Carbon High Chromium with Mo and V

KEY FEATURES :

- Basic type electrode
- Extra hard and sound weld
- Non machinable deposit
- Deposit can be finished by grinding
- Can be operated in horizontal position
- High hardness in single layer
- Can withstand mild impact
- Recommended buffer layer of Betachrome-N on austenitic Mn steels

WELDING POSITION :



AC (70 V) / DCEP

TYPICAL APPLICATIONS :

- Excavator parts, Bucket teeth
- Cane cutting knives
- Metal cutting and forming tools
- Caterpillar treads
- Crusher hammers and jaws
- Disintegrator hammers
- Shear blades
- Conveyor buckets and screws

REDRYING CONDITION : 250-300°C for minimum 1 hr.

PHYSICAL PROPERTIES :

Condition	Hardness, 1 layer HRc (BHN)
As Welded	55-58 (560-600)

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	180-230	5	4	20
6.3 x 450	230-280	5	4	20

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