

ZEDALLOY 604

HARDFACING (Abrasion-Impact Resistance)

ALLOY BASIS

C, Cr, Mn, Si

KEY FEATURES:

- Slag free weld deposit
- Resistant to abrasion in combination with friction and moderate impact
- Smooth weld bead with nil spatter
- Suited for application involving high stress grinding abrasion


TYPICAL APPLICATIONS:




- Excavator teeth, Ploughshares
- Road graders, Crusher hammers, Caterpillar treads, Plough shares
- Overlays on machine parts
- Cane & bamboo cutting knives
- Exhaust blades, scraper bars
- Shears & Croppers, Oil expellers, etc.
- Excavator buckets, Bucket teeth

PHYSICAL PROPERTIES :

Condition	Hardness, HRc
As Welded	57-62

PARAMETERS - PACKING DATA:

Ø x L, mm 3.15 x 450 4.0 x 450 5.0 x 450	Amperage, A 90-120 120-160 160-190	 AC (70 V) / DCEP / DCEN REDRYING CONDITION: 100°C for 1 hour (If electrodes are moist).
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Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
			

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