



ZEDALLOY VB

HARD FACING (High Abrasion)



Alloyed Cast Iron Electrode for Hardfacing

ALLOY BASIS :

High Carbon Medium Chromium

KEY FEATURES :

- Basic type coating
- Non machinable alloyed cast iron deposit
- Deposit surface does not deteriorate through furrowing, local plastic flow and micro cracking
- Weld deposit can withstand severe abrasion, moderate impact and metal to metal wear
- Resistant to scratching and grinding abrasion

WELDING POSITION :



AC (100 V) / DCEP

TYPICAL APPLICATIONS :

- Concrete Mixer Blades
- Muller Tyres, Dippers
- Screw Conveyors
- Plough Shares
- Cement Die Rings
- Oil Expeller Worms
- Scraper Blades
- Excavator Teeth

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

PHYSICAL PROPERTIES :

Condition	Hardness, 3 layer HRc (BHN)
As Welded	58 (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	90-110	5	4	20
4.0 x 450	110-140	5	4	20
5.0 x 450	140-180	5	4	20

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