



ZEDALLOY 680

HARD FACING (High Abrasion)



Hardfacing Electrode for Extreme wear Resistance at Elevated Temperature

ALLOY BASIS :

C, Cr, Nb, V, Mo, W

KEY FEATURES :

- Excellent arc stike/re-strike
- Complex refractory carbides in eutectic matrix
- Minimal slag, smooth weld bead
- Non machinable deposit
- High volume fraction carbides offer excellent wear resistance up to 650°C
- Recommended for single pass deposit

WELDING POSITION :



AC (100 V) / DCEP

TYPICAL APPLICATIONS :

- Clinker grinders, Conveyor chains, Sinter handling equipment, Auger flights, Sinter star breakers, Slurry pumps
- Coke pusher shoes, Billet conveyor guides, Hot slag conveyors, Pug mill knives, Coal burner nozzles, Conveyor screw

REDRYING CONDITION : 105°C for 1 hr

PHYSICAL PROPERTIES :

Condition	Hardness, 1 Layer HRc
As Welded	65-70

Machinability

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Abrasion Resistance



Impact Resistance

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Corrosion Resistance



PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Carton/Box	Net wt./Box, Kg.
3.15 x 350	90-160	5	4	20
4.0 x 350	120-180	5	4	20
5.0 x 350	180-220	5	4	20

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