



ZEDALLOY 650

HARD FACING (Moderate - Abrasion Impact)

ALLOY BASIS

C, Cr, Mn, Si, V

KEY FEATURES:

- All position welding electrode
- Smooth arc with low spatter
- Multi-layer deposit without fissures / cracks
- Weld metal is air hardening type
- High hardness even in single layer
- Weld deposit resistant to severe abrasion & moderate impact


TYPICAL APPLICATIONS:




- Hot & cold punching dies
- Bulldozer blades, Bucket lips, Chutes
- Applications involving metal to mineral wear, Conveyors
- Metal cutting & forming tools
- Road graders, Crusher hammers, Caterpillar treads, Plough shares
- Cane & bamboo cutting knives
- Shears & Croppers, Oil expellers, etc.

PHYSICAL PROPERTIES :

Condition	Hardness, HRC
As Welded	57-62

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
3.15 x 450	90-120	 AC (70 V) / DCEP / DCEN REDRYING CONDITION: 100°C for 1 hour (If electrodes are moist).
4.0 x 450	120-170	
5.0 x 450	160-260	

Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
			

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