



# ZEDALLOY K

HARD FACING (Abrasion - Corrosion)

### ALLOY BASIS

C, Mn, Cr, Mo, V, W

### KEY FEATURES:

- Basic type electrode
- Optimum resistance against metal to metal wear, abrasion and impact
- Air hardenable
- Non machinable weld
- Preheating is required when used on hardenable steels


### TYPICAL APPLICATIONS:

- Blanking and Forming dies
- Cutting tools
- Mining tools
- Shear blades
- Hog & Chipper knives
- Wood working tools
- Rolling mill guides
- Ingot fitting tongs




### MECHANICAL PROPERTIES OF ALL WELD METAL:

| Condition | 3 Layer, Hardness, HRc (BHN) Typical |
|-----------|--------------------------------------|
| As Welded | 58 (600)                             |

### PARAMETERS - PACKING DATA:

|  |   |   |
|--|---|---|
| <b>Ø x L, mm</b><br>3.15 x 450<br>4.0 x 450<br>5.0 x 450 | <b>Amperage, A</b><br>100-130<br>140-180<br>180-200 |  <b>AC (70 OCV) /DCEP</b><br><br><b>REDRYING CONDITION:</b><br>250-300°C for minimum 1 hr. |
|--|---|---|

Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kg each.

| Machinability | Abrasion Resistance   | Impact Resistance   | Corrosion Resistance  |
|---------------|---|---|---|
|               |  |  |  |

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