



ZEDALLOY WD

HARD FACING (Moderate - Abrasion Impact)

ALLOY BASIS:

C, Cr, Mo, V

KEY FEATURES:

- All position electrode for multi-layer deposits free from any cracks
- Smooth arc with nil spatter
- Air hardening type weld metal
- Resistant to high abrasion & impact

TYPICAL APPLICATIONS:

- Weld surfacing of wire drawing drums
- Excavating equipments
- Buckets, Shovels
- Cold stamping tools
- Dies, Punches, Hammers
- Scrapers, Tampers

PHYSICAL PROPERTIES:

Condition	2 Layer Hardness, HRc
As welded	57-62

Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance

PARAMETERS - PACKING DATA:

<p>Ø x L, mm 3.15 x 450 4.0 x 450</p>	<p>Amperage, A 90-130 130-170</p>	<p> AC (70 V)/DCEP/DCEN</p> <p>REDRYING CONDITION: 100°C for 1 hour (If electrodes are moist)</p>	<p>All Positions</p>
--	--	---	----------------------

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

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