

ZEDALLOY 604

HARDFACING (High Abrasion-Moderate Impact Resistance)

ALLOY BASIS

C, Cr, Mn, Si

KEY FEATURES:




- Slag free weld deposit
- Resistant to abrasion in combination with friction and moderate impact
- Smooth weld bead with nil spatter
- Suited for application involving high stress grinding abrasion

TYPICAL APPLICATIONS:


- Excavator teeth, Ploughshares
- Overlays on machine parts
- Exhaust blades, scraper bars
- Excavator buckets, Bucket teeth
- Cultivators, Impellers, Cams, dredger buckets, oil expeller worms
- Coal crushing applications of mill hammers, pulverizers, cement grinder rings

PHYSICAL PROPERTIES :

Condition	2 Layers Hardness, HRc
As Welded	56-62

Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
			

PARAMETERS - PACKING DATA:

Ø x L, mm 3.15 x 450 4.0 x 450 5.0 x 450	Amperage, A 90-120 120-160 160-190	 AC (70 OCV) / DCEP REDRYING CONDITION: 200-300°C for minimum 1 hour
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Physical Properties: With increase in number of squares, property improves