

ZEDALLOY 650

HARDFACING (Abrasion-Impact Resistance)

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


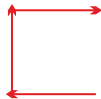
TYPICAL APPLICATIONS:

- 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	All Positions, except vertical Down 
4.0 x 450	120-170		
5.0 x 450	160-260		
		REDRYING CONDITION: 100°C for 1 hour (If electrodes are moist).	

Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
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Physical Properties: With increase in number of squares, property improves