



ZEDALLOY 680

HARD FACING (High Abrasion)

ALLOY BASIS

C, Cr, Nb, V, Mo

KEY FEATURES:

- Excellent arc stike/re-strike
- Complex refractory carbides in eutectic matrix
- Minimal slag, smooth weld bead
- Non machinable deposit
- High volume fraction carbides offer excellent wear resistance up to 650oC
- Recommended for single pass deposit


TYPICAL APPLICATIONS:

- Clinker grinders, Conveyor chains, Sinter handling equipment, Auger flights, Sinter star breakers, Slurry pumps
- Coke pusher shoes, Billet conveyor guides, Hot slag conveyors, Pug mill knives, Coal burner nozzles, Conveyor screw

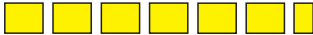

MECHANICAL PROPERTIES OF ALL WELD METAL:

Condition	Hardness,1 Layer HRC, Typical
As Welded	64

PARAMETERS - PACKING DATA:

Ø x L, mm 3.15 x 450 4.0 x 450 5.0 x 450	Amperage, A 90-160 120-180 180-220	 AC (70 OCV) / DCEP REDRYING CONDITION: 110°C for 1 hr
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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