

ZEDALLOY 400B

HARD FACING (Build Up)



Hardfacing Electrode for High Wear and Impact Application

ALLOY BASIS:

Low Carbon Low Chromium

KEY FEATURES:

- Basic type heavy coating
- Possible to deposit heavy build up without the need of buffer layers
- Machining only with sintered hard metal tipped tools
- Highly wear resistant overlays can withstand impact & shock
- Recommended buffer layer of Betachrome -N/ND on crack sensitive steels

WELDING POSITION:







AC (70 V) / DCEP

TYPICAL APPLICATIONS:

- Rebuilding rail crossing and switch points, Wheel flanges
- Wear parts of Dredgers
- Striking tools, Dies, Tyres

- Slide surfaces subjected to heavy wear
- Polygon edges, Bearing surfaces
- Lower dies & punches

REDRYING CONDITION:

250-300°C for minimum 1 hr.

REBAKING CONDITION:

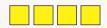
300-350°C for 2 hrs.

PHYSICAL PROPERTIES:

Condition	Hardness, 3 Layer HRc (BHN)	
As Welded	40-45 (370-420)	
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Machinability Abrasion Resistance Impact Resistance Corrosion Resistance









PARAMETERS - PACKING DATA :						
Ø x L, mm	Amperage, A	Wt./Carton, Kg	Carton/Box	Net wt./Box, Kg.		
3.15 x 350	100-135	5	4	20		
4.0 x 350	120-180	5	4	20		
5.0 x 350	170-240	5	4	20		

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