



ADOR WELDING LIMITED

READY RECKONER FOR HARDFACING ELECTRODES

Sr No	Product	Hardness (BHN)	Machinability	Abrasion resistance	Impact resistance	Corrosion resistance	Buffer Layer (Recommended)	Characteristics	Applications
1	ZEDALLOY-250	250	Good	Good	Average	Not Applicable	TENALLOY-16	Deposits air-hardening type of weld metal. It has excellent arc stability, low spatter level and easy restriking. Weld beads are smooth, uniform and of excellent appearance.	For reclamations of Gears, Pinion Teeth, Tram Tyres, Pulleys, Shafts, Couplings, Sugarcane Crushers, Spindles, Gear Wheels, Hammers, Axles etc.
2	ZEDALLOY-350	350	Good (Only with carbide tools)	Excellent	Good	Not Applicable	TENALLOY-16	Deposits air-hardening type of weld metal. It has excellent arc stability, low spatter level and easy striking/restriking. Weld beads are smooth, uniform and of excellent appearance.	For reclamations of Conveyor Parts , Cog Wheels, Cams, Cold Punching Dies, Gear Shafts, Drive Sprockets, Latch Bars And Plates, Plough shears, Pulleys, Shafts, Couplings, Steel Castings, Shear Blades, Wobblers Ends, Axles etc
3	ZEDALLOY-350(LH)	350	Highly suitable with carbide tools	Excellent	Good	Not Applicable	TENALLOY-16	Hydrogen controlled, air-hardening type weld metal. Excellent arc stability and low spatter level. Easy striking/restriking. Smooth and uniform weld bead with excellent appearance.	For reclamations of Conveyor Parts , Cog Wheels, Cams, Cold Punching Dies, Gear Shafts, Drive Sprockets, Latch Bars And Plates, Plough shears, Pulleys, Shafts, Couplings, Steel Castings, Shear Blades, Wobblers Ends, Axles etc
4	ZEDALLOY-500	450-550	Non-Machinable	Excellent	Good	Not Applicable	TENALLOY-16	Air-hardening type weld metal. Surface finished by grinding only. Weld metal can withstand atmospheric corrosion and suitable applications in the areas involving high stress abrasion at room temperature, medium impact and resistance to metal-to-metal wear. Appreciable increase in the impact resistance occurs after tempering.	Shear blades, cutting tools, forming dies, ingot-tongs, crane wheels, etc.
5	ZEDALLOY-550	550	Non-Machinable	Excellent	Good	Not Applicable	TENALLOY-16	Air-hardening type weld metal. Weld metal can withstand heavy abrasion, friction and moderate impact. Excellent arc stability and low spatter level with easy striking/restriking. Weld beads are smooth, uniform and of excellent appearance.	For reclamations of Sugarcane Cutting Knives, Bamboo Chipper Knives, Disintegrator Hammers, Crane Wheels, Shear Blades, Metal Cutting And Forming Tools, Punches, Dies, Drilling Bits, Shears, Oil Expeller Worms, Crushers, Hammers, Mine Rails, Caterpillar Threads , Conveyor Parts, etc.
6	ZEDALLOY-550 (LH)	550	Non-Machinable/ Only Grinding	Excellent	Good	Not Applicable	TENALLOY-16	Hydrogen controlled, Iron powder electrode. Weld metal can withstand heavy abrasion, friction and moderate impact. Excellent arc stability and low spatter level with easy striking/restriking. Weld beads are smooth, uniform and of excellent appearance.	For reclamations of Sugarcane Cutting Knives, Bamboo Chipper Knives, Disintegrator Hammers, Crane Wheels, Shear Blades, Metal Cutting And Forming Tools, Punches, Dies, Drilling Bits, Shears, Oil Expeller Worms, Crushers, Hammers, Mine Rails, Caterpillar Threads , Conveyor Parts, etc.
7	ZEDALLOY-600	600	Non-Machinable/ Only Grinding	Good	Good	Moderate	Not Required	Hydrogen controlled, basic type iron powder electrode, giving smooth arc, medium penetration and least spatter. Slag easily detachable. Can be used on high carbon, high sulphur steels without giving any underbead crack and porosity.	For reclamations of Sugarcane Cutting Knives, Bamboo Chipper Knives, Disintegrator Hammers, Crane Wheels, Shear Blades, Metal Cutting And Forming Tools, Punches, Dies, Drilling Bits, Shears, Oil Expeller Worms, Crushers, Hammers, Mine Rails, Caterpillar Threads , Conveyor Parts, etc.
8	ZEDALLOY-VB	600	Non-Machinable	Excellent	Moderate	Average	Not Required	Deposited weld metal is alloyed cast iron, which is hard and extremely resistant to abrasion and metal-to-metal wear. Specially designed for scratching abrasion and occasional grinding abrasion. The built-up surface does not deteriorate through furrowing, local plastic flow and microcracking. Striking/restriking easy.	For reclamations of Oil Expeller Worms, Concrete Mixer Blades, Scrapper Blades, Screw Conveyors, Cement Die Rings, Muller Tires, Plough Shears, Dippers, Excavator teeth, etc



9	ZEDALLOY-12 Mn	200	Good	Average	Excellent	Average	BETACHROME-N	Work hardenable weld metal with 12% Mn. Under severe impact conditions, hardness increases upto 500BHN. Ideal for gouging type abrasion wear. Excellent arc stability and low spatter level with easy striking/restriking. Weld beads are smooth, uniform and of excellent appearance.	For reclamations of Dredger Bucket Teeth, Rock Crushing Jaw, Mn Steel Rails, Rail cross covers, Cement Grinding Rings, Austenitic Mn Steel Castings, Crusher Mantles, Hammers, etc
10	ZEDALLOY-16 Mn	200	Good	Average	Excellent	Average	BETACHROME	Weld metal with modified austenitic Manganese steel, with soft arc, easily controlled slag and weld bead of smooth regular contour. Under severe impact conditions, hardness increases upto 500BHN.	Austenitic Manganese steel parts such as stone crusher jobs, dredger bucket teeth, hammers of grinding mills, Manganese steel rails. For repairing and building up austenitic manganese steel castings in foundries.
11	ZEDALLOY-16 Cr	200	Good	Average	Excellent	Good	Not Required	Weld metal has excellent resistance to combined effect of impact, abrasion and corrosion. Weld deposit work-hardens under impact from 200BHN to 500BHN and gives improved life to the component. Pleasing performance.	For reclamations of Dipper Teeth, Shovel Tracks, Rock Crushers, Coal Mining Cutters, Charging Rams, Tractor Gougers, Dipper Lips, Pump Housing, Conveyor Rolls, Conveyor Buckets, Crusher Mantles, Screw Flights, Truck Chains, Mill Hammers, Scrapper Blades, Dredger Cutter Teeth, Plough Sheares shovel, Drive Sprockets, Scarifier Teeth, Pulverizer Ploughs , Sand Pump Impellers, Ingot Tongs .etc
12	ZEDALLOY-20 Cr	250	Good	Average	Excellent	Good	Not Required	Work hardenable weld metal which is semi-austenitic with excellent arc stability and low spatter level. Striking/restriking easy. Weld beads are smooth, uniform and of excellent appearance. Weld deposit work-hardens under impact from 250BHN to 400BHN and on peening upto 500BHN.	For reclamations of Dipper Teeth, Shovel Tracks, Rock Crushers, Coal Mining Cutters, Charging Rams, Pump Housing, Conveyor Rolls, Conveyor Buckets, Crusher Mantles, Screw Flights, Truck Chains, Mill Hammers, Scrapper Blades, Dredge Cutter Teeth, Pulverizer Ploughs , Sand Pump Impellers, Ingot Tongs .etc
13	ZEDALLOY-K	600	Non-Machinable	Excellent	Excellent	Good	Not Required	Air-hardening type weld metal. Metallurgically balanced to obtain optimum resistance to metal-to-metal wear, abrasion and impact. When used on hardenable steels, suitable preheating to be done. Weld beads are smooth, uniform and of excellent appearance.	For usage in Hog And Chipper Knives, Bleaching Dies, Forming Dies, Cams Scalp Hooks, Cutting tools, Shear Blades, Mining Tools, Ingot Fitting Tongs, Rolling Mill Guides, Wood Working Tools, etc.
14	SUPER ZEDALLOY	600	Non-Machinable	Excellent even for temperature upto 1000°C	Poor	Good	Not Required	Easy striking/restriking. Weld beads are smooth, uniform and of excellent appearance. To avoid cracking use only one or two layers.	For usage in Ceramic Industry. For reclamations of Plough Shears, Cultivator Shovels, Coke Chutes, Sand Blasting Equipment, Conveyors, Screws, Grinding Rings, Edge Runner Scappers, Parts Of Earth Moving And Mining Equipments, etc
15	SUPER ZEDALLOY-Ni	550	Non-Machinable	Excellent even for temperature upto 500°C	Poor	Good	Not Required	It retains hardness even at elevated temperatures. Use only one or two layers to avoid cracking.	Ideal for applications where abrasion and high temperature corrosion condition exist as in the Blast furnace bells and hoppers. Also for reclamation of Steel mill equipments. Useful for Metallurgical Industry and Chemical Plants
16	ZEDALLOY-600B	600	Non-Machinable/ Only Grinding	Good	Good	Moderate	BETACHROME-N	Hydrogen-controlled, iron powder electrode giving smooth arc, medium penetration and least spatter with easy slag detachability. Low hydrogen enables it to be used on high carbon and high sulphur steels without giving underbead cracks and porosity. It can withstand wear due to abrasion as well as impact.	Hardfacing of excavator parts, bucket teeth, drilling bits, conveyor screws, crusher jaws, cane cutting knives, bamboo chipper knives, disintegrator hammers, crane tools, punches, dies, drilling bits, shears, oil expeller worms, crusher hammers, mine rails, caterpillar trends, crane wheels, conveyor buckets and such other parts which are subjected to friction and abrasion.
17	ZEDALLOY-650B	650	Non-Machinable/ Only Grinding	Good	Good	Moderate	BETACHROME-N	Hydrogen-controlled, iron powder electrode giving smooth arc, medium penetration and least spatter with easy slag detachability. Low hydrogen enables it to be used on high carbon and high sulphur steels without giving underbead cracks and porosity	Hardfacing of rock drill bits, excavator parts, bucket teeth, drilling bits, conveyor screws, crusher jaws, cane cutting knives, bamboo chipper knives, disintegrator hammers, crane tools, punches, dies, drilling bits, shears, oil expeller worms, crusher hammers, mine rails, caterpillar trends, crane wheels, conveyor buckets and such other parts which are subjected to friction and abrasion.
18	MAGNACANE	550	Non-Machinable/ Only Grinding	Good	Good	Moderate	Not Required	Super heavy basic coated electrode specifically designed for hardfacing rollers in sugar mills even in situ condition. The electrode strikes automatically even on wet mill rollers. The electrode allows deposition of hemispherical dots on the roll.	Mill rollers of sugar mills



India' Welding Power House

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