

SME ZE50

ELECTRODE WITH RESISTANCE TO HIGH ABRASION AND MODERATE IMPACT

Alloy Basis

C, Mn, Si, Cr

Characteristics :

SME ZE50 is a rutile-coated, air-hardening electrode with non-machinable deposit offering high resistance to spalling, cracking and high-stress abrasion. It can also withstand moderate impact.



Typical Application

Applications include dis-integrator hammers, excavator teeth, shear & bulldozer blades, bucket lips, metal cutting & forming tools, crane wheels, caterpillar treads and cane cutting knives.

Mechanical Properties

Hardness:

As Welded: 54 – 56 HRC

Welding Current : AC, DCEP

| | | | |
|----------------|----------|-----------|-----------|
| Size (Ø mm) | 3.15 | 4.00 | 5.00 |
| Current (amps) | 90 - 120 | 120 - 170 | 160 - 260 |

Availability:

Standard Size: 5.0, 4.0, 3.15 in 350 & 450 mm length

Packing: 2.50, 5.00 KG

Procedure

Clean the area to be welded thoroughly. For low-alloy and high-carbon tool steels, preheat to approximately 250° C before welding. Allow the material to cool slowly to room temperature. Use SME 7016 as a buffer layer when welding hard base materials.