

SME ZF50

ELECTRODE WITH RESISTANCE TO SEVERE ABRASION AND MODERATE IMPACT

Alloy Basis

C, Cr, Mn, Si

Characteristics :

SME ZF50 is an air-hardening electrode designed for hard surfacing applications on mild steel and low alloy carbon steel. This all position electrode produces a smooth arc with minimal spatter and crack-free multi-layer deposits. The weld deposits are non-machinable and offer excellent resistance to severe abrasion and moderate impact.



Typical Applications

Applications include hot and cold punching dies, mine rails, dredger bucket lips, bulldozer blades, plough shares, chutes, crusher hammers, drilling bits, bamboo and cane cutting knives, conveyor buckets, crane wheels, oil expellers and more.

Mechanical Properties

Hardness:

As Welded: 55 – 60 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 A08 or SME 7016 as a buffer layer when welding on austenitic carbon steel.