

AI-1765

Description

AI 1765 is a solid MIG wire for the build-up, overlay or joining of cast iron. It can be used on ductile, nodular, grey and Ni-resist irons and for joining these alloys to cast and mild or stainless steels. The unique chemistry of **AI 1765** provides weld deposits that are fully machinable with a single pass. Under normal circumstances, if dilution is kept to a minimum, there is no undercutting and weld deposits can be machined through the fusion zone, even with high-speed steel tooling.

Applications

AI 1765 should be applied in stringer beads with only a slight side-to-side oscillating motion. All craters must be back filled. Optimum bead contour is slightly convex. Peening will help to relieve stresses.

Consult your Alloys International representative for recommended pre-heats.

Typical Weldmetal Analysis

C	Mn	Si	Cr	Ni	Fe	Wc	Co	Ti	Mo	Cu	Nb
				45.00						55.00	

Mechanical Properties of Weldmetal

Tensile strength	:	414 MPa (60,000 psi)
Hardness	:	100 - 150 BHN

Welding Instructions

Current: DC +ve

Shielding Gas: Although both Argon and Argon/CO₂ can be used as a gas cover, pure Argon will help this alloy to wet better to cast iron and produce better welding characteristics.

Welding Parameters

	VOLTS	AMPS
0.9mm	20 - 22	90 - 120
1.2mm	22 - 24	110 - 160

Available Sizes

0.9 & 1.2 mm in 15kg MIG spools

Disclaimer

All figures in this datasheet should be considered indicative only. No guarantee is made as to their accuracy. All figures subject to change without notice. Batch analysis is available for all products sold. Should you require any further information, please contact us at sales@alloysint.com.au.