

AI-1543

Specifications

AS/NZS 2576-2460-B7

DIN 8555 MF 10-GF-65-G

Description and Applications

A high quality complex carbide surfacing alloy giving exceptional resistance to all types of abrasion. Deposit achieves full hardness in first layer. Microstructure - primary carbides, M_7C_3 eutectic carbides and Nodular Niobium carbides (spherical) in a pearlitic matrix.

Applications include: Groundnut oil expeller screws, brickwork extruder augers and mixers, wear plates, screens in the coal industry, bucket teeth on bucket-wheel excavators, shovel bucket teeth and lips.

Deposit Thickness

Max. 8mm in 2 or 3 layers. The deposit will crack readily.

Alloys International recommended for applications involving severe high stress abrasion combined with low impact at temperatures not exceeding 450° C.

Typical Weldmetal Analysis

C	Mn	Si	Cr	Fe	Nb
5.50	0.70	0.50	22.00	Bal	7.00

Mechanical Properties of Weldmetal

	As Welded
Abrasion Resistance	Exceptional
Impact Resistance	Reasonable
Deposit Efficiency	85%
Hardness	62 HRc
Wear Index	0.3%
Machineability	Grinding

Welding Parameters

Diameter (mm)	Current type	Amps	Stick out (mm)
1.6	DC(+)	180-200	30-35
2.4	DC(+)	250-300	30-35

Also Available as **AI-0543** Coated Electrodes and **AI-0543T** Tubular Electrodes.

Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position

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



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