

AI-15306

Description and Applications

AI-15306 is a easy to use self-shielded welding wire for use by a wide range of welders whether experienced or not. It is designed for high deposition rate welding for build-ups, butt and fillet welds. It is a versatile, easy to use wire with excellent operator appeal. It has a soft arc which makes it easy to use for gaps and large misfits.

Depositing a weld that is low in sulphur and this then in turn offers increased resistance to hot cracking. It is designed to be used with a long stick out and the flux cored capability makes it ideal to use onsite applications.

Applications include: Build-up of large castings, large fillet welding. Good operator appeal.

Typical Weldmetal Analysis

C	Mn	Si	Al	P	S	Fe
0.32	0.57	0.15	1.35	0.01	0.008	Bal

Mechanical Properties of Weldmetal

	As Welded
UTS	100,000 psi
Elongation	22%

Smooth Arc Action and Low Spatter
Ideal for high deposition requirements
Excellent out-of-position weldability

Welding Instructions

Self-shielded flux-cored wires, as the name suggests, contain materials to provide a gas shielding. This self-shielded wires require a stick out of 15-25 mm. This is so that the heating effect on the wire will cause the gas shielding materials to decompose and provide the shield. Too short a stick out does not allow the shield to form and porosity can result.

AI-15306 is designed to operate in spray transfer mode at lower amps and voltages with DC Reverse Polarity than is usual for a particular wire diameter. The low heat input makes it particularly suited for fabrication of thin gauge materials.

Welding Parameters

Diameter (mm)	Current type	Amps	Stick-out	Position
1.2	DC /AC	100-250	12-15mm	Vertical-up and overhead
1.6	DC /AC	150-300	12-20mm	Vertical-up and overhead

Disclaimer

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