

## AI-0205

### Specifications

**AWS/ASME 11 C SFA 5.4: E 505-15,16**

### Description and Applications

**AI-0205** is an electrode used for welding base metal of the same composition.

(505 stainless steel), usually in the form of pipe, tube or castings. The material is air hardening, and therefore both preheat and postheat treatment and stress relieving must be used. Excellent resistance to oxidation up to temperatures of 700°C.

### Typical Weldmetal Analysis

C	Mn	Si	Cr	Fe
0.08	0.50	0.60	9.00	Bal

### Mechanical Properties of Weldmetal

	As Welded
Tensile Strength:	600Mpa
Yield Strength (0.2%):	325Mpa
Elongation:	30% (4d)
Charpy V:	80J (20°C)
Post Weld Heat Treatment:	850°C (2 Hours)

### Welding Parameters

Diameter (mm)	Current type	Amps
2.5	DC /AC	50-90
3.2	DC /AC	80-120
4.0	DC /AC	110-200

Redry at 300°C for at least 1Hr

### Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position, (4G) Overhead position, (3G, 3F, 5G up) Vertical Position Up

### 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](mailto:sales@alloysint.com.au)



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