

AI-0240

Specifications

AWS/ASME 11C SFA E312-16

ISO 3581 : E29 9 R23

BS 2926: 29.9 R

Description and Applications

Universal rutile coated electrode for welding heterogeneous joints, hardening steels, armour steels and generally all difficult to weld and dissimilar steels.

AI-0240 has exceptional weldability, the ability to weld at very low current (thus minimizing heat input) and has automatic slag removal.

Typical Weldmetal Analysis

C	Mn	Si	Cr	Ni	Fe
0.13	1.00	0.80	29.30	9.00	Bal

Mechanical Properties of Weldmetal

	As Welded
Tensile Strength:	800 MPa
Yield Strength (0.2%):	680 MPa
Elongation:	22% (4d)
Microstructure:	Austenite + Ferrite

Welding Parameters

Diameter (mm)	Current type	Amps
1.6	DC/AC	25-40
2.0	DC/AC	40-60
2.5	DC /AC	50-90
3.2	DC /AC	80-120
4.0	DC /AC	110-160

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



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