

AI-0395

Specifications

AWS/ASME 2C SFA 5.11: E NiCrMo-5

DIN 1736: S-Ni Mo 15 Cr 15 W

Description and Applications

AI-0395 is an alloy providing excellent deposits, which will withstand the single or combined effects of oxidation, corrosion, erosion and mechanical stress up to temperatures of 1100°C. **AI-0395** also has excellent joining properties for nickel-based alloys such as Hastalloy and Inconel to themselves or to mild or stainless steel.

Applications include: Building up of soaking pit furnace points, hot shear blades, mandrels and various forging tools, charge car arms, molten metal spouts and chutes, coal combustion activator pallets, rolling and wire drawing guides, piercing mandrels etc.

Typical Weldmetal Analysis

C	Cr	Ni	Fe	W	Mo
0.03	16.0	Bal	5.00	4.00	16.0

Mechanical Properties of Weldmetal

	As Welded
Tensile Strength:	740 MPa
Yield Strength (0.2%):	510 MPa
Elongation:	25% (4d)
Recovery:	160%
Hardness:	200HB 350HB (After Work Hardening)

Welding Parameters

Diameter (mm)	Current type	Amps
2.5	DC +ve	50-80
3.2	DC +ve	80-120
4.0	DC +ve	120-150
5.0	DC +ve	150-180

Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position, (4F) Horizontal overhead 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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