

AI-0501

Specifications

AS/NZS 2576 : 1215-A4

W.T.I.A Tech Note 4 : 1215-A4

Description and Applications

Basic coated electrode for surfacing parts subject to heavy impacts. Joining of 14% Mn steels. Underlay prior to hard surfacing.

Applications include: railway equipment (Mn steel), large crusher parts, crusher hammers, toothed shells of coke cutters, shovel and dredging buckets.

Typical Weldmetal Analysis

C	Mn	Si	Cr	Ni	Fe	Mo
0.95	13.8	0.1	3.7	3.6	Bal	0.7

Mechanical Properties of Weldmetal

	As Welded
Hardness	200HB as welded 500HB hardened
Wear Coefficient	75%
Shock Resistance	Excellent
Abrasion resistance	Medium after work hardening
Machineability	Possible prior to work hardening

Welding Parameters

Diameter (mm)	Current type	Amps
3.2	DC /AC	80-110
4.0	DC /AC	110-150
5.0	DC /AC	150-180

MIG wire: **AI-1705**

Open arc wire: **AI-1505**

Welding Positions

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