

## AI-0508

### Specifications

**AS/NZS** 2576 : 1540-A4

**W.T.I.A** Tech Note 4 : 1540-A4

**DIN** E3 - 45+-umhult

### Description and Applications

Rutile coated electrode for retouching edges and rebuilding steel parts for hot and cold service. Applications include: Shear blades, forging dies, runways, cams, and slides. Cladding of mild or low alloy steels for the same. Applications involving metal to metal wear up to 550°C with thermal and mechanical shock properties.

### Typical Weldmetal Analysis

| C    | Mn   | Si   | Cr   | Fe  | W    | V    |
|------|------|------|------|-----|------|------|
| 0.13 | 0.75 | 0.70 | 2.60 | Bal | 4.40 | 0.65 |

### Mechanical Properties of Weldmetal

|                             | As Welded |
|-----------------------------|-----------|
| Shock Resistance            | Good      |
| Metal-to-Metal Wear Resist  | Very Good |
| High Temperature Resistance | Very Good |
| Thermal Shock Resistance    | Excellent |
| Machineability              | Yes       |
| Hardness                    | 43 HRc    |

### Welding Parameters

| Diameter (mm) | Current type | Amps    |
|---------------|--------------|---------|
| 2.5           | DC /AC       | 55-80   |
| 3.2           | DC /AC       | 80-110  |
| 4.0           | DC /AC       | 110-140 |

### Welding Positions

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

### Disclaimer

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