

## AI-0511

### Description and Applications

Rutile coated electrode for surfacing parts subject to abrasion with high compression stress or shocks. Also used to resist metal-to-metal wear in wet or dry conditions. Applications include: Crusher hammers, mixers, dredging parts, gears, cams etc.

### Typical Weldmetal Analysis

C	Mn	Si	Cr	Ni	Fe
0.50	0.70	1.80	1.80	9.70	Bal

### Mechanical Properties of Weldmetal

	As Welded
Shock Resistance	Good
Abrasion Resistance	Good
Machineability	Difficult
Wear Coefficient	70%
Hardness	54HR 300HB (at 500°C)

### Welding Parameters

Diameter (mm)	Current type	Amps
3.2	DC /AC	80-120
4.0	DC /AC	120-150
5.0	DC /AC	150-180

### Welding Positions

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

### Disclaimer

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