

## AI-0512

### Specifications

**AS/NZS** 2576 : 1550-A4

**W.T.I.A** Tech Note 4 : 1550-A4

**DIN** 8555 : E3-SST umhult

### Description and Applications

Rutile coated electrode for surfacing tools for high temp service.

Applications include: Dies, hot shear blades, pit points and stamping punches. Produces a tool steel type deposit capable of resisting metal-to-metal wear up to 500°C.

### Typical Weldmetal Analysis

C	Mn	Si	Cr	Fe	Mo
0.33	0.10	0.70	8.35	Bal	2.75

### Mechanical Properties of Weldmetal

	As Welded
Shock Resistance	Medium
Metal-to-Metal Wear Resist	Very Good
High Temperature Resistance	Very Good
Thermal Shock Resistance	Good
Machineability	No (unless heat treated)
Hardness	55 HRc

### Welding Parameters

Diameter (mm)	Current type	Amps
2.5	DC /AC	50-80
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

All figures in this datasheet should be considered indicative only. No guarantee is made as to their accuracy.

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