

## AI-0516

### Specifications

**AS/NZS 2576** : 1860-A4

**W.T.I.A Tech Note 4** : 1860-A4

### Description and Applications

Basic coated electrode for surfacing parts subject to severe abrasion with medium impact likely to be absorbed elastically.

Electrode features excellent weldability; for example, surfacing of conveyor screws, mixer blades, sand pumps, coal pulverisers, scrapers.

### Typical Weldmetal Analysis

C	Cr	Fe	Mo
4.3	9.7	Bal	1.8

### Mechanical Properties of Weldmetal

	As Welded
Shock Resistance	Good
Abrasion Resistance	Excellent
Hardness	60HRc
Wear Coefficient	2%
Machineability	Grinding

### 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, (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](mailto:sales@alloysint.com.au)



**ALLOYS INTERNATIONAL PTY LTD**

25 Raymond Road Laverton North Victoria 3026

Telephone: +61 3 8368 2222 | Facsimile: +61 3 8368 2200

**ABN** 53 112 712 286

[sales@alloysint.com.au](mailto:sales@alloysint.com.au) | [www.alloysint.com.au](http://www.alloysint.com.au)