

## AI-0520

### Specifications

**AS/NZS 2576** : 1560-A4

**W.T.I.A. Tech Note 4** : 1560-A4

**DIN 8555**: E3-60T

### Description and Applications

Rutile coated electrode for surfacing parts subject to metal-to-metal wear up to 550°C without thermal shocks.

**Applications include:** cold shear blades, wire guides, twist guides, machine tools and milling cutters. This alloy produces a high-speed steel type deposit.

### Typical Weldmetal Analysis

| C   | Mn  | Si  | Cr  | W   | Fe  | Mo  | V   |
|-----|-----|-----|-----|-----|-----|-----|-----|
| 1.0 | 0.1 | 1.0 | 4.5 | 2.2 | Bal | 9.5 | 2.1 |

### Mechanical Properties of Weldmetal

|                             | As Welded                   |
|-----------------------------|-----------------------------|
| Hardness                    | 60Hrc                       |
| Thermal Shock               | Moderate                    |
| Shock Resistance            | Medium                      |
| Abrasion Resistance         | Medium after work hardening |
| Machineability              | No, unless heat treated     |
| High Temperature Resistance | Very good                   |

### Welding Parameters

| Diameter (mm) | Current type | Amps    |
|---------------|--------------|---------|
| 2.5           | DC /AC       | 50-80   |
| 3.2           | DC /AC       | 80-110  |
| 4.0           | DC /AC       | 110-150 |

TIG wire: AI-0520T

MIG wire: AI-1720

### Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position, (4F) Horizontal overhead position, (4G) Overhead position, (3G, 3F, 5G up) Vertical Position Up

### Disclaimer

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