

AI-0535

Specifications

AS/NZS 2576 : 2355-A1

W.T.I.A. Tech Note 4 : 2355-A1

Description and Applications

Synthetic basic coated electrode with high recovery (160%) for hardfacing. Resisting mineral wear by friction, combined with shocks and compression – austenitic matrix containing Cr carbides. Pleasant fusion – self releasing slag – deposit resists to corrosion (32% Cr) and to heat up to 200°C. Eventual surfacing in 1, 2 or 3 layers – for all pieces subject to high abrasion combined with a good resistance to shocks. Only machinable by grinding.

Applications include: excavating and crashing equipment, surfacing of endless screws, mixer blades, pump bodies for abrasive materials, concrete pumps, ore crushing, press screws for bricks.

Typical Weldmetal Analysis

C	Mn	Si	Cr	Fe
3.5	1.0	1.0	32.0	Bal

Mechanical Properties of Weldmetal

	As Welded
Hardness	58HRc
Wear Coefficient	2%
Shock Resistance	Medium
Abrasion Resistance	Excellent
Machineability	Grinding only

Welding Parameters

Diameter (mm)	Current type	Amps
3.2	DC /AC	90-120
4.0	DC /AC	120-150
5.0	DC /AC	150-180

Open arc wire: **AI-1555 & AI-1568**

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



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 | www.alloysint.com.au