

## AI-0538

### Specifications

**AS/NZS** 2576 : 2360-A4

**W.T.I.A.** Tech Note 4 : 2360-A4

### Description and Applications

Hardfacing electrode with high efficiency basic coating (190%). Highly resistance to abrasion due to its high content of Cr and C: the service life of surfaced piece can be 50 times longer as for conventional electrodes of similar hardness. Austenitic matrix with Cr carbides – resistance to moderate shock – deposit 1 or 2 layers max – agreeable fusion – no slag – bead very smooth. For all pieces subject to low or moderate shock where an important resistance to abrasion is required. The formation of cracks on the metal deposit is normal for this type of deposit.

Applications include: Crusher parts, conveyor screws, excavator teeth, crushing of mineral materials, concrete pumps, ploughshare, pump bodies for abrasive materials.

### Typical Weldmetal Analysis

C	Mn	Si	Cr	Fe
5.0	0.5	1.0	35.0	Bal

### Mechanical Properties of Weldmetal

	As Welded
Hardness	60-63HRc
Wear Coefficient	0.7%
Shock Resistance	Medium
Abrasion Resistance	Excellent
Machineability	Grinding only

### Welding Parameters

Diameter (mm)	Current type	Amps
3.2	DC /AC	110-130
4.0	DC /AC	130-150
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.

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**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)