

## AI-0538T

### Specifications

AS/NZS 2576 : 2355-A1

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

### Description and Applications

**AI-0538T** is a tubular electrode depositing an Austenitic Chromium White Iron. Direct application to Austenitic Manganese Steels and Carbon Steels is possible.

**AI-0538T** has a moisture resistant coating. There is no alloy contribution from the flux. Relief checks are normal in deposits. Multi layers up to three runs acceptable.

Features fume control and ease of running. 6.0 mm may be easily used in out of position deposits. No preheat required on mild steel or grey iron.

### Typical Weldmetal Analysis

C	Mn	Cr	Fe
5.50	1.50	40.00	Bal

### Mechanical Properties of Weldmetal

	As Welded
Impact Resistance	Good
Shock Resistance	Moderate
Abrasion Resistance	Very Good
Wear Coefficient	1%
Hardness	58 HRc single layer
Machineability	By grinding only

### Welding Instructions

Coverage per kg 420 - 440 sq. cm x 3.0 mm thick.

### Welding Parameters

Diameter (mm)	Current type	Amps	Positions
6.0	DC /AC	85-135	All Positions
8.0	DC /AC	130-190	All Positions except Vertical Down
12.0	DC /AC	200-43	Horizontal only

Identification light blue end tip



### 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 & (3G, 3F, 5G down) Vertical position down

### Disclaimer

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