

AI-0540

Specifications

AS/NZS 2576 : 2450-A4

W.T.I.A. Tech Note 4 : 2450-A4

Description and Applications

Basic coated, high recovery electrode for surfacing parts subject to severe abrasion combined with high impacts.

Applications include: Gyrotory crusher hammers, coke cutters, wear plates on hoppers, vibrating screens, scrap collector plates, star crushers and rolls crushers. This alloy can be welded onto 14% Manganese steel without underlay.

Typical Weldmetal Analysis

| C | Mn | Si | Cr | Fe | Nb |
|------|------|------|-------|-----|------|
| 4.00 | 1.20 | 1.00 | 22.00 | Bal | 6.00 |

Mechanical Properties of Weldmetal

| | As Welded |
|---------------------|-----------|
| Shock Resistance | Good |
| Abrasion Resistance | Excellent |
| Machineability | Grinding |
| Wear Coefficient | 1% |
| Hardness | 57HRc |

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 |

Available as Open Arc Wire: **AI-1540**

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



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