

AI-0543

Specifications

AS/NZS 2576 : 2460-A4

W.T.I.A. Tech Note 4 : 2460-A4

Description and Applications

High recovery, basic coated electrode for surfacing parts subject to severe abrasion with medium impacts at temperatures not higher than 450°C.

Applications include: Screws of refractory material presses, screws of brick presses, and screws of cement presses. This alloy also has the characteristic of achieving full hardness in the first layer.

Typical Weldmetal Analysis

C	Mn	Si	Cr	Fe	Nb
7.00	2.00	2.00	24.00	Bal	7.00

Mechanical Properties of Weldmetal

	As Welded
Shock Resistance	Moderate
Abrasion Resistance	Exceptional
Machineability	Grinding
Wear Coefficient	0.5%
Hardness	63HRc

Welding Parameters

Diameter (mm)	Current type	Amps
3.2	DC /AC	80-110
4.0	DC /AC	110-150
5.0	DC /AC	150-180

Also Available as Open Arc Wire: **AI-1543**

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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