

AI-0543T

Specifications

AS/NZS 2576 : 2460-A1

W.T.I.A. Tech Note 4 : 2460-A1

Description and Applications

AI-0543T is a tubular electrode designed to give very good impact resistance yet retain a high hardness. There is less relief checking than Austenitic White Irons. 6.0 mm may be deposited out of position. Moisture resistant coating. No alloy contribution from the flux. Multi layers up to three runs acceptable. No preheat required on mild steel or grey iron. **AI-0543T** deposits complex carbide alloy. Applications include: Rail ballast tampers, crusher hammers, dredge teeth, dozer end plates, ripper teeth, grizzly bars and steel work mill guide.

Typical Weldmetal Analysis

C	Mn	Si	Cr	Fe	Mo	Nb
4.00	0.80	1.50	26.50	Bal	0.90	7.90

Mechanical Properties of Weldmetal

	As Welded
Shock Resistance	Moderate
Abrasion Resistance	Exceptional
High Temperature Resistance	Good (up to 550°C)
Microstructure	Austenitic
Wear Index	0.7%
Hardness	61 HRc
Machineability	Grinding only

Welding Instructions

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

Identification: red end tip

Welding Parameters

Diameter (mm)	Current type	Amps	Positions
6.0	DC /AC	90-130	All Positions
8.0	DC /AC	135-185	All Positions except Vertical Down
12.0	DC /AC	200-430	Horizontal only



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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