

AI-0545

Specifications

AS/NZS 2576 : 2460-A4

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

Description and Applications

Basic coated electrode for surfacing parts subject to extremely severe abrasion with medium impacts at temperatures up to 600-650°C.

Applications include: Sinter crushers, scraper wires in zinc industries, scrap collectors, mechanical stokers and blast furnace chutes.

Typical Weldmetal Analysis

C	Mn	Si	Cr	Fe	W	V	Mo	Nb
6.00	1.50	2.00	22.00	Bal	3.00	1.00	6.00	6.00

Mechanical Properties of Weldmetal

	As Welded
Shock Resistance	Moderate
Abrasion Resistance	Exceptional
Machineability	Grinding
Wear Coefficient	0.3%
Hardness	65HRc 50HRc (at 600°C)

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

Also available as Open Arc Wire: **AI-1545**

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

