

AI-0553T

Specifications

AS/NZS 2576 : 2360-A1

W.T.I.A. Tech Note 4 : 2360-A1

Description and Applications

AI-0553T is a tubular electrode containing tungsten carbides in a matrix of chromium carbide designed to give excellent abrasion resistance and moderate impact resistance at high hardness. The 6mm electrode can be used out of position. Deposits will relief check. Up to two passes may be applied.

AI-0553T has a moisture resistant flux coating. There is no alloy contribution from the flux. No preheat is required for direct application to grey cast iron or low alloy steel.

Applications include: Rail ballast tampers, Dredge Teeth, Grizzly Bars, Mixer paddles, Steel mill guides, brickworks components etc.

Typical Weldmetal Analysis

C	Mn	Si	Cr	Fe	W	Mo
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Mechanical Properties of Weldmetal

	As Welded
Shock Resistance	Moderate
Abrasion Resistance	Exceptional
Machineability	Grinding
Wear Coefficient	0.25%
Hardness	Matric 64-68HRc

Welding Instructions

6.0mm diameter is ideal for overhead or vertical welding.

Coverage per kg 350 - 400 sq cm x 3.0 mm thick.

Identification: Gold Tip

Welding Parameters

Diameter (mm)	Current type	Amps	Positions
6.0	DC /AC	90-130	All Positions
8.0	DC /AC	120-175	All Positions except vertical down
12.0	DC /AC	200-400	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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