

AI-0554T

Specifications

AS/NZS 2576 : 2355-A1

W.T.I.A. Tech Note 4 : 2355-A1

Description and Applications

AI-0554T is a tubular electrode, which has lower carbon and chromium than AI 558T to give improved impact performance.

- Features ease of deposition, controlled fume.
- Minimum or no splatter. Deposits will relief check.
- Multi layers may be applied Moisture resistant flux coating.
- No preheat required for direct application to grey cast iron or low alloy steel.

Applications include: Brickworks Swing and Fixed Hammers, Ripper Teeth, Dozer End Plates, Dredge Teeth, Grizzly Bars, etc.

Typical Weldmetal Analysis

C	Mn	Cr	Fe
5.00	3.50	35.00	Bal

Mechanical Properties of Weldmetal

	As Welded
Shock Resistance	Very Good
Abrasion Resistance	Good
Machineability	Grinding
Wear Coefficient	2%
Hardness	53-55HRc

Welding Instructions

6.0mm diameter is ideal for overhead or vertical welding.

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

Identification: Black 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

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