

AI-0560

Specifications

AS/NZS 2576 : 1860-A4

W.T.I.A. Tech Note 4 : 1860-A4

Description and Applications

AI-0560 is a basic coated electrode for hardfacing. **AI-0560** is a martensitic carbide providing good abrasion and medium impact resistance. It is excellent for resistance against compressive stresses and impact.

Applications include: Parts of steel, cast steel, high Mn steel, subject to simultaneous impact, abrasion and compression. Typical application fields include earth moving equipment, drilling equipment, crusher jaws, excavator teeth, cones, hammermill hammers and cold cutting tools.

Typical Weldmetal Analysis

| C | Mn | Si | Cr | Fe |
|-----|------|-----|-----|-----|
| 0.5 | 0.45 | 2.3 | 9.0 | Bal |

Mechanical Properties of Weldmetal

| | As Welded |
|---------------------|--|
| Hardness | 56-59HRC Undiluted 36-40HRC 2 layers thick on high Mn steel |
| Impact Resistance | Average |
| Abrasion Resistance | Good |
| Machineability | Grinding only |

Welding Parameters

| Diameter (mm) | Current type | Amps |
|---------------|--------------|---------|
| 2.5 | DC /AC | 80-100 |
| 3.2 | DC /AC | 100-140 |
| 4.0 | DC /AC | 140-270 |
| 5.0 | DC /AC | 180-210 |

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.

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