

## AI-0579 Canegrip

### Description and Applications

A coated stick electrode designed primarily for the on-site surfacing of cast-iron sugar mill rolls to enhance the roughness and prevent excessive wear taking place on the gripping surfaces of the rolls. **AI-0579** can also be used generally for surfacing parts subject to severe abrasion with medium impact. The alloy consists of chromium carbides in an austenitic matrix resulting in a deposit, which has an excellent combination of impact and abrasion resistance.

### Typical Weldmetal Analysis

| C   | Mn  | Si  | Cr   | Fe  | Mo  |
|-----|-----|-----|------|-----|-----|
| 5.0 | 1.0 | 1.5 | 27.0 | Bal | 1.0 |

### Mechanical Properties of Weldmetal

|                     | As Welded |
|---------------------|-----------|
| Shock Resistance    | Medium    |
| Abrasion Resistance | Excellent |
| Machineability      | Grinding  |
| Wear Co-Efficient   | 2%        |
| Hardness            | 56HRc     |

### Welding Parameters

| Diameter (mm) | Current type | Amps    |
|---------------|--------------|---------|
| 2.5           | DC /AC       | 80-110  |
| 3.2           | DC /AC       | 110-130 |
| 4.0           | DC /AC       | 130-150 |

Also Available as Open Arc Wire: **AI-1579** "Canegrip"

### Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G)

### Disclaimer

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