

AI-0612E

Specifications

AWS/ASME 11 C SFA 5.13: ECoCr-B

Description and Applications

AI-0612E is a rutile coated electrode (Equivalent to Stellite™* 12). Particularly suited for surfacing parts subject to either the single or combined effect metal-to-metal wear, and/or temperatures from 500°C to 800°C in corrosive media.

Applications include: Tools for cutting wood, paper, board, carpet and plastic.

*Stellite is a trademark of the Kennametal Corporation

Typical Weldmetal Analysis

C	Cr	W	Co
1.4	31	8.4	Bal

Mechanical Properties of Weldmetal

	As Welded
Hardness	48HRC 32HRC at 500°C
Metal-to-metal wear resistance	Excellent
Shock resistance	Medium
High temperature resistance	Excellent
Thermal Shock Resistance	Moderate
Abrasion resistance	Good
Machineability	Machineable with care

Welding Instructions

Castings, billets, HIP'ed castings

Welding Parameters

Diameter (mm)	Current type	Amps
2.5	DC /AC	90-120
3.2	DC /AC	120-140
4.0	DC /AC	140-160

Bare/TIG rods: **AI-0612E**

MIG wire: **AI-1712**

Arc spray wire: **AI-1812**

PTA/Laser cladding powder: **AI-2012**

HVOF powder: **AI-2612**

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



ALLOYS INTERNATIONAL PTY LTD

25 Raymond Road Laverton North Victoria 3026

Telephone: +61 3 8368 2222 | Facsimile: +61 3 8368 2200

ABN 53 112 712 286

sales@alloysint.com.au | www.alloysint.com.au