

AI-0760T

Description and Applications

AI-0760T is a tubular electrode offering the optimum abrasion resistance. Alloy contains Cast tungsten carbide in granular form in an iron matrix. The coating on the covered electrodes is moisture resistant. Deposits contain carbides 2200 HV. The deposits cannot be drilled or machined. Finish by grinding only if required.

Due to exceptional hardness relief check cracking is normal. A controlled fume low dilution product. Magnetic. **AI-0760T** may be applied direct to plain and low carbon steels.

Applications include: Oil Drill Collars, Scrapers, Augers and parts subjected to very high abrasion

Typical Weldmetal Analysis

60% tungsten carbide in an iron matrix.

Mechanical Properties of Weldmetal

	As Welded
Matrix	Austenite with a little martensite
First Layer	30% Tungsten Carbide 35% Iron-Tungsten Carbide 35% Austenite + Martensite
Second Layer	35% Tungsten Carbide 30% Iron-Tungsten Carbide 35% Austenite + Martensite
Machinability	Grinding
Hardness	65-68 HRC

Deposit Properties

Deposit is magnetic and cannot be flame-cut.

Welding Positions

Horizontal, Vertical, 45° Incline

Recommended Amperages

6.0 mm 70 - 110 (note lower amps result in less dilution)

8.0 mm 100 – 160

Available Sizes

6.0 mm & 8.0 mm diameter

AI-0760T is also available as **AI-0760B** Bar Rod form for TIG of Oxy Acetylene deposition and

AI-1590 Open Arc Wire

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



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