

AI-1558

Specifications

DIN 8555 MF 6-GF-60-GP

Description and Applications

A cladding or build-up alloy containing finely dispersed Titanium carbides in a hard, high chromium martensitic matrix.

The deposit is heat treatable and forgeable.

Deposit thickness: depends upon application and procedure used. AI 1558 is designed to give excellent resistance to heavy impact, gouging and grinding abrasion together with a good resistance to cracking. May be welded 15-18mm thick in 5 to 6 layers.

Applications include: Crusher cylinders, crusher hammers, agricultural tools, asphalt tools, car shredder, asphalt mixer blades, shovel bucket teeth and lips, bulldozer blades, cane knives and shredders, gyratory crusher mantles, bed knives and anvils in the wood pulp industry.

Typical Weldmetal Analysis

C	Mn	Si	Cr	Fe	Ti	Mo
1.80	1.50	0.25	7.00	Bal	5.50	1.40

Mechanical Properties of Weldmetal

	As Welded
Impact Resistance	Exceptional
Abrasion Resistance	Good
Deposit Efficiency	87-90%
Wear Index	2%
Hardness	58 HRc
Machineability	Grinding only (Cannot be flame cut)

Welding Instructions

DC +ve 24-34 volts

180-350 amps (dependent on wire size, application etc)

Welding Parameters

Diameter (mm)	Current type	Amps	Stick out (mm)
1.2	DC(+)	120-150	30-35
1.6	DC(+)	150-250	30-35
2.4	DC(+)	250-350	30-35
2.8	DC(+)	300-450	30-35

*other sizes available by request



Welding Positions

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

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

