

AI-1567VC

Specifications

DIN 8555 : MF6-60-GP

DIN EN14700 : T Fe 8-60-GP

Description and Applications

AI-1567VC is a C-, Cr-, Mo-alloyed flux-cored wire with the addition of up to 15% special refractory (vanadium) carbides for added hardness and high abrasive wear resistance. This alloy is best suited to protecting parts that are exposed to stresses featuring high pressure wear with high levels of abrasion. It is therefore well suited to hardfacing crusher rolls, pulleys, drums etc. where a high degree of invasive dust or sand is present. It belongs to a class of "crack-free" weld deposits for these specific applications. The micro structure of the deposit is martensitic with evenly distributed hard carbides. For base materials that are high in carbon or difficult to weld, a buffer layer of **AI-1707** is recommended. Preheating is recommended. Use in Open Arc or MIG.

Applications include: Pulleys, guides, rolls, drums, crusher segments where high levels of friction due to sand / mineral abrasion are primary wear factors.

Typical Weldmetal Analysis

C	Mn	Si	Cr	Fe	Vc	Mo
>3.00	2.50	1.00	6.00	Bal	<15.00	>0.50

Mechanical Properties of Weldmetal

	As Welded
Abrasion Resistance	Excellent
Impact Resistance	Moderate
Deposit Efficiency	90-92%
Hardness	58-62 HRc
Machineability	Grinding only
Oxy Acetylene Cutting	Not Possible

Welding Parameters

Diameter (mm)	Current type	Amps	Stick-out
1.6	DC(+)	180-240	30-35 mm
2.0	DC(+)	200-260	30-35 mm
2.4	DC(+)	260-280	30-35 mm
2.8	DC(+)	280-320	35-35 mm



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

