

AI-1568

Specifications

AS/NZS 2576 2360 B7

DIN 8555 : MF 10-GF-65-G

Description and Applications

AI-1568 is a high quality-surfacing alloy designed for continuous, open arc cladding. The alloy will produce coatings, which have excellent resistance to abrasion, even when service conditions include some impact and corrosion.

Microstructure	Primary Chromium Carbides Eutectic Carbides Residual & Transformed Austenite	Approx. 70% Approx. 25% Approx. 5%
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Alloy is particularly successful in applications involving gouging and high stress abrasion in heavy industry. It is suitable for application on to manganese steels.

Deposit Thickness: Because of its high hardness a maximum of 2-3 layers (6-8 mm) is recommended under most circumstances of abrasion and medium impact.

Applications include: Asphalt machinery, palm oil expeller screws, ground nut oil expeller screws, slurry pipes, bends and fittings, pug mill augers, catalytic converter pipes, screw conveyors, dredge pump impellers and casings, shovel bucket teeth and lips, dredge cutters etc.

Typical Weldmetal Analysis

C	Mn	Si	Cr	Fe
5.5	1.1	1.2	25.7	Bal

Mechanical Properties of Weldmetal

	As Welded
Abrasion Resistance	Excellent
Impact Resistance	Moderate
Deposit Efficiency	90%
Wear Index	0.36% (Grit) / 0.35% (Standard)
Wear Index Comparison	AI-1555 52% (Grit)
Hardness	62 HRc
Machineability	Grinding only
Oxy Acetylene Cutting	Not Possible



Welding Parameters

Diameter	Polarity	Amps	Stick-out
1.2	DC+ve	150-180	30-35 mm
1.6	DC+ve	180-250	30-35 mm
2.0	DC+ve	200-300	30-35 mm
2.4	DC+ve	300-400	30-35 mm
2.8	DC+ve	350-600	35-40 mm

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

