

## AI-1685

### Specifications

DIN 8555: UP 6-GF-55-GT

### Description and Applications

**AI-1685** is a martensitic alloy giving excellent resistance to metal-to-metal and low stress abrasive wear with impact and high compressive stresses.

The deposit is heat treatable and forgeable.

**Applications:** Suitable for steel mill rolls, blast furnace bells (seat area), dredger-buckets, cylinders etc.

### Typical Weldmetal Analysis using AI SA Flux

C	Mn	Si	Cr	Fe	W	Mo
0.40	1.50	0.60	6.20	Bal	1.70	1.80

### Mechanical Properties of Weldmetal

As Welded	
Microstructure	Martensite
Machineability	Grinding only
Oxyacetylene Cutting	Flame cutting is difficult
Deposit Thickness	Depends upon application and procedure used
Welding Flux	AI-16 Record 605

### Welding Parameters

Diameter (mm)	Current type	Amps	Stick-out	Welding Speed (cm/min)	Flux Consumption (kg/kg wire)
3.2	DC+ve	325-450	30-35	35-45	1.1
4.0	DC +ve	400-450	30-35	40-50	1.1

25Kg Spools, 250Kg Auto Packs by special order

### 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](mailto:sales@alloysint.com.au)



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