

AI-1685L

Specifications

DIN 8555: UPI-GF-300-GP

Description and Applications

AI-1685L is a martensitic alloy giving excellent resistance to metal-to-metal and low stress abrasive wear 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
0.20	1.60	0.30	6.00	Bal	1.50	1.60

Mechanical Properties of Weldmetal

As Welded	
Microstructure	Martensite
Machineability	Good with tungsten carbides or cubic boron nitride tipped tools
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

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



ALLOYS INTERNATIONAL PTY LTD
25 Raymond Road Laverton North Victoria 3026
Telephone: +61 3 8368 2222 | Facsimile: +61 3 8368 2200

ABN 53 112 712 286

sales@alloysint.com.au | www.alloysint.com.au