

AI-0250

Specifications

AS/NZS 1553.3 : E312-17

AWS/ASME A5.4 : E312-17

Description and Applications

“Weld-All” rutile coated stainless type of electrode especially developed for use on dissimilar steels, hard to weld steels (eg tool steels, spring steels, armour plate and wear plate), unknown steels and for buffer layers under surfacing alloys.

AI-0250 provides ultra smooth, very low amperage, porosity free weld in all positions with excellent strike and restrike characteristics, high crack resistivity and automatic slag release.

Applications include: tools, dies, springs, gears, frames, cast steel components, and areas requiring heat and corrosion resistance.

Typical Weldmetal Analysis

C	Mn	Cr	Fe	Ni	Si
<0.1	1	29.5	Bal	9.5	0.9

Mechanical Properties of Weldmetal

	As Welded
Tensile Strength	820MPa
Yield Strength (0.2%)	690Mpa
Elongation	22% (4d)
Microstructure	Austenite + Ferrite

Welding Parameters

Diameter (mm)	Current type	Amps
1.6	DC /AC	25-40
2.0	DC /AC	40-60
2.5	DC /AC	50-90
3.2	DC /AC	80-120
4.0	DC /AC	110-160

Also available as TIG: **AI-0250T** and MIG wire: **AI-1780**

Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position, (4G) Overhead position, (3G, 3F, 5G up) Vertical Position Up

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



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