

AI-0601E

Specifications

AWS/ASME II C SFA 5.21: ECoCr-C

Description and Applications

AI-0601E is a cobalt based Alloy 1 rutile coated electrode for surfacing parts subject to either the single or combined effect of medium abrasion or metal-to-metal wear, and/or temperatures from 500°C to 800°C in corrosive media. The addition of tungsten gives excellent wear resistance.

Applications include: rolling mill guides, pump bushes and spindles, steam turbine parts, extrusion dies.

Typical Weldmetal Analysis

C	Mn	Si	Cr	Ni	Fe	W	Co	Mo
2.2	2.0	2.0	32.0	3.0	5.0	12.0	Bal	1.0

Mechanical Properties of Weldmetal

	As Welded
Hardness	56HRc 37HRc at 500°C
Metal-to-metal wear resistance	Excellent
High temperature resistance	Excellent
Thermal Shock Resistance	Moderate
Abrasion resistance	Very Good
Machineability	Grinding only

Welding Parameters

Diameter (mm)	Current type	Amps
2.5	DC /AC	90-120
3.2	DC /AC	120-140
4.0	DC /AC	140-160
5.0	DC /AC	160-180

Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position

Available Forms

Bare/TIG rods: **AI-0601B**

MIG wire: **AI-1701**

Arc spray wire: **AI-1801**

PTA/Laser Powder **AI-2001**

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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