

AI-1564

64HRC Single-Layer Hardfacing Wire

Specifications

AS/NZS 2576	EN 14700
2465-B7	T Fe 16-65-GZ

Description

AI-1564 is a highly C-Cr-B-W-V-alloyed open-arc flux-cored hardfacing wire, which deposits a very hard martensitic micro structure full of complex carbides. It is unique from all other similar wires in the range, because it reaches full hardness of 64HRC in a single layer, where typically 2-3 layers are required. This makes achieving the specified hardness a lot more economical than with most hardfacing materials.

Applications

Cement, mineral and brick industry, steel industry, refuse-incinerator plants, composting plants, mineral crushing, paddle wheels. Widely used for agricultural applications.

Typical Weldmetal Analysis (wt%)

C	Si	Mn	Cr	V	W	B	Fe
4.5	1.0	1.6	24	0.8	0.8	1.0	Base

Microstructure

Primary Chromium Carbides	Eutectic Carbides	Residual & Transformed Austenite
Approx. 70%	Approx. 25%	Approx. 5%

Mechanical Properties of Weldmetal

Abrasion Resistance	Excellent	Hardness	64 HRc
Impact Resistance	Moderate	Machineability	Grinding only

Weld Instructions

Size (mm)	Stock Code	Current type	Volts	Amps	Stick-out (mm)	Gas	Packaging	Weld Positions
1.6	AI-1564-16	DC(+)	26-30	180-200	35-40 mm	Nil – Open Arc	15kg spool	 DOWNHAND