

PRODUCT DATA SHEET

Tube Alloy AP-O

Tube Alloy AP-O is a self-shielded wire depositing a high chromium austenitic manganese alloy. The deposit will work harden readily.

Applications

Tube Alloy AP-O is suitable for use in joining austenitic manganese steels to themselves, carbon steels and alloy steels. It is also suitable for use on bucket teeth and lips, crusher jaws and cones, grizzly bars and fingers, hammer mills, hydroelectric turbines, impactor crusher bars, muller tyres, sizing screens and interparticle crushers.

Classifications

DIN	8555	MF8-GF-200/55-GKNP
-----	------	--------------------

Typical Chemical Analysis (All weld metal)

% Carbon	0,4	% Silicon	0,3
% Manganese	16,5	% Chromium	13,0

Typical Mechanical Properties

Abrasion Resistance	Fair
Impact Resistance	Excellent
Machinability	Difficult
Flame Cutting	Cannot be flame cut
Microstructure	Austenitic
Hardness (As Deposited)	18 - 24
Hardness (Work Hardened)	50 - 55
Non-magnetic	

Welding Data

(DC+)

Diameter (mm)	Current		Electrode Stick Out	Deposition Rate (kg/hr)
	Amps (A)	Volts (V)		
1,6	275 - 350	24 - 27	25 - 38	4,5
2,8	400 - 450	26 - 29	38 - 51	6,4

Packing Data

Diameter (mm)	Spool Mass (kg)	Spool Type	Item Number
1,6	11,3	Spool	W077072
2,8	27,2	Coil	W077069

The information contained or otherwise referenced herein is presented only as typical without guarantee or warranty, and Afrox expressly disclaims any liability incurred from any reliance therein. No data is to be construed as recommended for any welding condition or technique not controlled by Afrox.

For more information contact the Afrox Customer Service Centre Tel: 0860 02 02 02
E-mail: customer.service@afrox.linde.com Website: www.afrox.com

