

Finalloys

The Final Welding Solution



**THE ULTIMATE
STRENGTH, CRACK
RESISTANT ELECTRODE
FOR "RISK-FREE"
WELDING OF
ALL" TYPES OF STEEL.
AST - 112**

FINALLOY AST - 112 AC or DC (RP)

SPECIAL FEATURES

- High tensile strength as welded 1,28,000 PSI work hardened 1,86,000 PSI.
- High elongation of 32%.
- Excellent machinability
- Special flux formulation eliminates slag inclusions.
- Stable on low, open circuit AC transformers
- All position welding

INTERNATIONAL SPECIFICATIONS

AWS / ASME II C SFA 5.4 E312-16
DIN 8556 E29 9 R 23 ISO 3581 E29.9 R 23
BS 2926 - 1984 29.9 R

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PRODUCT OF USA

APPLICATIONS

- For high strength joints subjected to impact, wear, heat and corrosion
- Surfacing & buildup of gear teeth, shaft, dies, tool steels
- Joining leaf and coil springs
- Ideal for use as a buffer layer for hard facing
- Welding of dissimilar and unknown
- Composition steels - S.S.to M.S., S.S.to C.S. etc.

MECHANICAL PROPERTIES OF AST-112

Undiluted Weld Metal

Tensile strength as welded
Work hardened
Yield strength
Elongation
Reduction of arc
Impact Energy
Hardness

Maximum Value up to:

128,000 psi (88 kgs/mm²)
186,000 psi (128 kgs/mm²)
90,000 psi (63 kgs/mm²)
32%
25%
50J: 68°F (20°C)
Rockwell B-97 Brinell 320

MICROSTRUCTURE

A duplex austenite/ferrite structure with about 40% ferrite

WELD METAL ANALYSIS (Typical Weight % for AST 112)

Cu	C	Mn	Cr	Si	S	Ni	P	Mo	Fe
.06	.1	.8	30	1	.01	10	.02	.12	Bal.

Finalloy AST - 112

Finalloys (FZE)

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