

Finalloys

The Final Welding Solution



**THE ULTIMATE
STRENGTH, CRACK
RESISTANT ELECTRODE
FOR "RISK-FREE"
WELDING OF
ALL" TYPES OF STEEL.
AST - 111**

FINALLOY AST - 111 AC or DC (RP)

SPECIAL FEATURES

- This is an ultimate electrode for welding all types of steels, without any danger of cracking or breakage special "FERRITE BALANCED" chemistry also serves as a "STUD PULL" electrode, because slag is designed to turn into powder
- An engineered deposited chemistry that has the perfect ratio of metallics to offer crack resistance for superior to any other brand.
- Special flux formulation eliminates slag interference in horizontal fillets

INTERNATIONAL CLASSIFICATIONS

AWS / ASME II C SFA 5.4 E312-17*
(* proprietary modification)

DIN 8556 E29.9 R 23 ISO 3581 E29.9 R 32
NFA 81-343: EZ 29.9 R EN 1600: E 29.9 R32


*The
Final Welding Solution*

PRODUCT OF USA

FINALLOY WELDING ALLOY

APPLICATIONS

FIN – AST 111 has exceptional strength and is crack resistance. It is ideal for repairing tools, dies, spring steel and any dissimilar metal combinations, except for the aluminum and copper alloys. It is best for repairing worn parts and as an underlay for hard facing.

MECHANICAL PROPERTIES OF AST-111

Undiluted Weld Metal

Tensile strength as welded

Work hardened

Elongation

Reduction of arc

Impact Energy

Hardness

Maximum Value up to:

128,000 psi (880 MPa)

186,000 psi (1282 MPa)

36%

25%

50J: 68°F (20°C)

Brinell 225

WELD METAL ANALYSIS

Microstructure: A duplex austenite/delta ferrite structure with a shaeffler ferrite value below 35%.

Special Specifications exceeding chemistry for extreme crack resistance.

Welding current & Instructions

Diameter (mm)	3/16 (5.0)	5/32 (4.0)	1/8 (3.25)	3/32 (2.5)
Minimum Amperage	130	75	60	35
Maximum Amperage	200	140	110	70

Finalloy AST-111

Finalloys (FZE)

SAIF - ZONE

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UNITED ARAB EMIRATES.

