

AI-1709

Specifications

AWS/ASME A5.22-80

Description and Applications

AI-1709 wire has been developed for high speed **all position** welding of stainless steels. **AI-1709** is used when the majority of the work is to be welded in the vertical position. The modified slag allows faster completion of vertical welds with very little loss of the excellent bead appearance in the flat position. X-Ray quality weld beads with smooth flat surfaces can be deposited vertical-up, overhead or vertical down at welding currents up to 200 Amps. The slag is removed easily and completely, leaving a weld bead comparable with a good quality covered electrode.

Typical Weldmetal Analysis

C	Mn	Si	Cr	Fe	Ni
0.03	1.80	0.90	24.50	Bal	13.00

Mechanical Properties of Weldmetal

	As Welded
Tensile Strength	660 MPa
Elongation	36% (50 mm)
FN	19
Shielding Gas	Ar + 1-3% O₂ or equivalent Ar + 2-5% CO₂ or equivalent

Welding Parameters

Diameter (mm)	Current type	Amps
1.2	DC(+)	150-220
1.6	DC(+)	180-300

Other sizes available to special order

Welding Positions

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

Disclaimer

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