

## AI-1703

### Specifications

**AWS/AWSE A 5.28:** ER80S-D2

**ISO 14341-A:** G 50 5 M G4Mo

### Description and Applications

**AI-1703** is an all-positional, alloyed solid MIG wire for the welding of high strength steels. Due to its higher deoxidant levels this wire offers excellent porosity free welds on dirty and rusty steels.

**Applications:** **AI-1703** is ideal for the welding of boilers, pressure vessels, pipelines as well as many applications in earthmoving and mining such as welding segments to ring gears and other areas where the component is subjected to dynamic loadings. With an elongation rating of 24% this alloy offers good resistance to cracking where parts may be constrained. Deposits of **AI-1703** may be removed by flame cutting.

### Typical Weldmetal Analysis

C	Mn	Si	P	Mo	Fe	S
0.075	1.74	0.65	0.015	0.48	Bal	0.012

### Mechanical Properties of Weldmetal

As Welded	
Yield Stress	585MPa
Elongation	24%
Tensile Strength	680MPa
<b>Shielding Gas</b>	<b>CO<sub>2</sub> or Argon + 2% O<sub>2</sub></b>

### Welding Parameters

Diameter (mm)	Current type	Amps
0.9mm	DC+ve	75-200
1.2mm*	DC+ve	120-350

\*By request only

### Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position, (4F) Horizontal overhead position, (4G) Overhead position, (3G, 3F, 5G up) Vertical Position Up & (3G, 3F, 5G down) Vertical position down

### Disclaimer

All figures in this datasheet should be considered indicative only. No guarantee is made as to their accuracy.

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