

## AI-1709LSi-FC

### Specifications

**AWS/ASME A5.22 E309LT1-1**

### Description and Applications

**AI-1709LSi-FC** is a flux-cored gas shielded MIG wire developed for high speed all position joining and cladding of stainless steels and dissimilar steels. The deposit exhibits excellent bead appearance in all positions. 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	Mo	S&P
0.03	1.21	0.59	23.11	Bal	13.56	0.04	<0.03

### Mechanical Properties of Weldmetal

	As Welded
Tensile Strength	>557MPa
Elongation	42% (50 mm)
Deposition rate	Up to 5kg/hour
Deposition efficiency	91%
<b>Shielding Gas</b>	<b>Ar + 1-3% O<sub>2</sub> or equivalent</b> <b>Ar + 2-5% CO<sub>2</sub> or equivalent</b>

### Welding Parameters

Diameter (mm)	Current type	Amps
1.2	DC/AC	150-220
1.6	DC/AC	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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