

AI-1714

Description and Applications

AI-1714 is a gas shielded MIG alloy depositing ferritic-martensitic steel containing 13% chrome, 5% nickel and 1% molybdenum, designed to resist metal-to-metal wear, corrosion and thermal fatigue fire cracking.

Applications: Suitable for continuous casting rolls, valve seats, impellers, steam turbine parts etc.

Typical Weldmetal Analysis

C	Mn	Si	Cr	Fe	Ni	Mo
0.07	0.50	0.80	12.50	Bal	5.00	1.00

Mechanical Properties of Weldmetal

	As Welded
Microstructure	Martensite, + 10% ferrite
Machineability	Good with metallic carbide tipped tools
Oxyacetylene cutting	Cannot be flame cut
Deposit Thickness	Depends upon application and procedure
Shielding Gas	98% Ar + 2% O₂ or 100% Ar

	RT	500°C	525 °C	550 °C	575 °C	600 °C
Hardness in 3 Layers HRC	41	43	41	49	37	35

Welding Parameters

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

Welding Positions

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

Disclaimer

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