

AI-1716LSi-FC

Specifications

AWS/ASME A5.22-80 E316LT1-1, E316LT1-4

Description and Applications

AI-1716LSi-FC is a flux-cored gas shielded MIG wire developed for high speed all position joining and cladding of stainless 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	Ni	Fe	Mo	S&P
0.029	1.33	0.57	18.35	12.50	Bal	2.50	<0.03

Mechanical Properties of Weldmetal

	As Welded
Tensile Strength (Rm)	>516MPa
Elongation (4d)	44% (50mm)
Deposition rate	Up to 5kg/hour
Deposition efficiency	91%
Shielding Gas	98% Ar + 2% O₂ or 100% Ar

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

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

All figures subject to change without notice. Batch analysis is available for all products sold. Should you require any further information, please contact us at sales@alloysint.com.au

