

AI-1720

Specifications

AWS/ASME A5.9 : ER2209

EN ISO 14343-A:G (22 9 3 NL)

DIN: W:Nr 1.44462

DIN 8556: SG X2CrNiMo 22 9 3

Description and Applications

AI-1720 is a gas shielded MIG alloy depositing ferritic-martensitic steel designed to resist metal-to-metal wear, corrosion and thermal fatigue.

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

Typical Weldmetal Analysis

C	Mn	Si	Cr	Fe	Ni	Mo
0.03	1.5	0.40	22	Bal	8.5	3.0

Mechanical Properties of Weldmetal

	As Welded
Microstructure	Martensite + ferrite
Machinability	Good with metallic carbide tipped tools
Oxyacetylene cutting	Cannot be flame cut
Deposit thickness	Depends upon application and procedure
Hardness	30-35HRc
Shielding gas	98% Ar + 2% O₂ or 100% Ar Argon + 2-5% CO₂

Welding Parameters

Diameter (mm)	Current type	Amps
0.9	DC(+)	90-150
1.2	DC(+)	150-220
1.6	DC(+)	180-300

15kg Spools

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.

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ALLOYS INTERNATIONAL PTY LTD

25 Raymond Road Laverton North Victoria 3026

Telephone: +61 3 8368 2222 | Facsimile: +61 3 8368 2200

ABN 53 112 712 286

sales@alloysint.com.au | www.alloysint.com.au