

AI-1766

Specifications

AWS/ASME A5.28 : ER90S-B3

Description and Applications

AI-1766 is a gas shielded, copper coated, solid MIG wire designed for joining and / or overlaying of high temperature and creep resistant steels. This wire is typically used for welding 2 ¼ Cr 1 Mo or ½ Cr ½ Mo ¼ V steels. These alloys are usually found in the petro-chemical or power generation industries.

Typical Weldmetal Analysis

C	Mn	Si	Cr	Ni	Fe	Cu	S	Mo	P
0.1	0.5	0.5	2.4	<0.1	Bal	0.1	0.01	1.0	0.015

Mechanical Properties of Weldmetal

	As Welded
Tensile Strength	655MPa
Yield Strength (0.2%)	540MPa
Elongation (4d)	23%
Hardness	HV 220
PWHT	690°C/4h (AWS=1h)
Shielding Gas	Ar + 1-3% O₂ or 2-20% CO₂

Welding Parameters

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

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.

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

