

AI-1704

Specifications

AWS A 5.28: ER80S-B2

Description and Applications

AI-1704 is 1.25Cr-0.5Mo content to be used for the welding of creep resistant steel.

Applications include: Chemical composition of **AI-1704** conforming to AWS specification. It is used in chemical industry and in the ammonia synthesis process, for heat exchangers, boilers, piping and pressure vessels for temperature service up to about 550°C. It will also find applications in the petro-chemical industries, suitable for facing on casting and for casting repairs. To be used under the shield of Ar+O₂.

Typical Weldmetal Analysis

C	Mn	Si	S	P	Cr	Mo	Cu
0.08	0.60	0.60	0.01	0.01	1.30	0.50	0.12

Mechanical Properties of Weldmetal

	As Welded
Tensile Strength	570MPa
Yield Strength (0.2%)	460MPa
Elongation	23%
Shielding Gas	Ar + O₂

Welding Parameters

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

Welding Instructions

Preheat and interpass temperature 150°C. PWHT at 620°C for an hour.

Welding Positions

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

Disclaimer

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