



Inox 317L AC/DC+

STAINLESS STEEL

DESCRIPTION

Rutile coated stainless steel 317L-17 type electrode designed for all position welding of Cr-Ni-Mo stainless steel grades (316, 316L, 317, 317L, 318, etc.)

CLASSIFICATION AWS A5.4 : E317L-17

TYPICAL APPLICATIONS

Welding of Cr-Ni-Mo steels for chemical plant, petroleum plants, refineries and pulp and paper, etc. Tanks, pipes, heat exchangers, etc.

BASE MATERIALS 316, 316L, 317, 317L, 318, etc

PROCEDURE

Clean welding area. Keep a short arc with the electrode slightly inclined or always in contact with the part. Remove flux between each pass. Use only dry electrode.

MECHANICAL PROPERTIES

Tensile strength: > 87 022 psi (> 600 MPa)
 Yield strength: > 69 618 psi (> 480 MPa)
 Elongation: > 35 - 37 %

TYPICAL WELD METAL COMPOSITION (%)

C	Cr	Ni	Mo	Mn	Cu
0.04	18.0 - 21.0	12.0 - 14.0	3.0 - 4.0	0.5 - 2.5	0.75

WELDING PARAMETERS

Diameter: 4.0 mm (5/32") 3.2 mm (1/8") 2.5 mm (3/32")
 Amperage: 130-160 A 90-120 A 60-90 A

WELDING POSITIONS



1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

Rev.: 15_03

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