

Meltolit

317L

AWS A 5.9: ER317L ISO 14343-A: 18 15 3 L

DESCRIPTION

317L-G is suitable for welding stainless steels with an alloy content between 16 to 21% Cr, 10 to 15% Ni and up to 3% Mo, stabilised and unstabilised types where enhanced resistance to pitting and acid corrosion is required.

WELDING POSITIONS



CURRENT

Mig, DC+
Tig, DC-

GAS

Mig, Ar/CO2(M12)
Tig, Ar(I1)

BASE MATERIALS

316, 316L, 316Ti, 317, 317L, 318

MECHANICAL PROPERTIES

<i>Rm (Mpa)</i>	<i>Rp 0,2 (Mpa)</i>	<i>A5 (%)</i>	<i>KV(j)</i>
630	480	35	+20°C – 135j -196°C – 55j

WELD METAL COMPOSITION(%)

C	Mn	Si	Cr	Mo	Ni		
0,01	1,4	0,4	18,9	3,7	13,7		

PACKAGING

Mig Dimension(mm)	0,8	1,0	1,2	
Spool size(kg)	5/15	5/15	5/15	
Tig Dimension(mm)	1,6x1000	2,0x1000	2,4x1000	3,2x1000
Box size(kg)	5	5	5	5

EQUIVALENT FILLER METALS

MMA	Meltolit 317L E
FCW	Meltolit 317L FCW/-PW