

TIG 317L



TIG 317L is used to weld 317/317L stainless steels in which the raised Mo level provides improved resistance to pitting in high chloride environments and to some acids (not nitric acid). These steels are used in marine, chemical process, papermaking, and food processing applications. Also suitable for 316/316L and their stabilised versions when the benefits of higher molybdenum weld metal are required to maximise weld area pitting resistance. Not suitable for structural service above about 400°C, or for cryogenic applications.

CLASSIFICATIONS

AWS	A5.9	ER317L
BS EN	12072	19 13 4 L

CHEMICAL ANALYSIS

% Carbon	0.015	% Chromium	19.00
% Manganese	1.500	% Nickel	14.00
% Silicon	0.400	% Molybdenum	3.500
% Sulphur	0.010	% Copper	0.150
% Phosphorus	0.020	% Ferrite	5.000

**TYPICAL MECHANICAL PROPERTIES
ALL WELD METAL**

Tensile Strength	630 MPa
0.2% Proof Stress	450 MPa
Elongation on 4d	35%
Impact Energy 20°C	75J

Microstructure
Austenite with 2-10FN (3-9% ferrite), typically 5FN.

PACKING DATA

TIG (DC-)

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
1.60	100	12	030-453	5
2.00	100	12	030-454	5
2.40	100	12	030-455	5
3.20	100	12	030-456	5

Suggested Shielding Gas: Argon

The information contained or otherwise referenced herein is presented only as typical without guarantee or warranty, and Afrox expressly disclaims any liability incurred from any reliance thereon. No data is to be construed as recommended for any welding condition or technique not controlled by Afrox.

For more information contact the Afrox Customer Service Centre,
tel: 0860 020202 or e-mail: customer.service@afrox.boc.com
Website: www.afrox.com

