



# Stainless Steel Solid Wire

MIG/TIG Welding

AWS A5.9: ER317L  
ISO 14343-A-2009 18 15 3 L

## SW-317L

### DESCRIPTION & APPLICATION

MIG/TIG Filler wire for the joining and overlay of Stainless Steels of similar composition. Joining of all Austenitic Stainless. Used in the food and Dairy Industry Austenitic deposit with up to 12% Ferrite, slightly magnetic.

### BASE MATERIALS

300 series Austenitic Stainless Steels, particularly Molybdenum bearing. CG8M Castings.

### MECHANICAL PROPERTIES

~630 UTS n/mm	~450 YIELD 0.2%	>30 ELONG A5%	>75 IMPACT (J) 20°C
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### METAL WELD COMPOSITION %

C	Si	Mn	Cr	Ni	Mo	S	P	Fe
0.015	0.45	1.8	18.5	13.5	3.5	0.02	0.025	BAL

### PACKAGING

15kg Spools (MIG)  
5kg Tubes (TIG)

### DIAMETERS

0.8, 1.0, 1.2mm (MIG)  
1.6, 2.4, 3.2mm (TIG)

### WELDING INSTRUCTIONS

Shielding gas MIG 5% or 20% CO<sub>2</sub> in Argon, or 2% Argon-Ox. TIG 100% Argon. Do not allow the base material to overheat, maintain interpass temperature below 150°C.

**For more details on welding of Stainless steel, please see our Information Sheets.**  
**Visit:** [www.westbrookwelding.co.uk/downloads](http://www.westbrookwelding.co.uk/downloads)