Selectarc Inox 317L

Stainless steel Electrode
With 3.5% Mo

Classification

AWS A5.4 : E 317L-17
ISO 3581-A : E Z 19 13 4 L R 3 2

EN 1600 : E Z 19 13 4 L R 3 2

Description & Applications

Low carbon Rutile-coated austenitic stainless steel electrode with ~3,5% of Molybdenum and approx. 8% ferrite. The electrode has a coating with very low moisture pick up. Soft fusion, without spatters, very easy slag removal, exceptional weld bead appearance, easy re-striking. Designed for welding and hardfacing stainless steels like 316L and 317L as well as stabilised grades. Pitting corrosion increased with regard Inox 316L.

Base materials:

Stainless steels for general use :

UNS	Steels	EN 10088	Alloy N°	UGINE
S31603	316L	X2CrNiMo17-12-2	1.4404	UGINOX 18-11ML
S31653	316LN	X2CrNiMoN17-13-3	1.4429	UGINOX 17-10 M
S31700	317	X5CrNiMo17-13-3	1.4449	
S31703	316LMo	X2CrNiMo18-14-3	1.4435	UGINOX 18-13MS
S31703	317L	X2CrNiMo18-15-4	1.4438	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Fe
0.02	0.8	0.7	19.0	13.0	3.5	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
470	600	35	+20°C 60

Welding Current & Instructions

Electrode	ØxL (mm)	2,0x300	2,5x300	3,2x350	4,0x350
Current	(A)	45	75	110	140

Redrying 1h at 250°C, if necessary. Interpass temperature: <200°C.

Ind.12

= +	~ 70V