

GRINOX 317L



IDENTIFICATION : GRINOX - E 317L - 16

CLASSIFICATION : AWS/SFA 5.4 : E 317L - 16

CHARACTERISTICS :

A medium heavy coated rutile type stainless steel electrode depositing low carbon 18/13/3.5 Mo austenitic stainless steel weld metal. Deposited weld metal has very high resistance to hot cracking, chemical corrosion upto 800oC and stress corrosion cracking. Molybdenum imparts resistance to corrosion of reducing nature. The deposited weld metal is of radiographic quality.

TYPICAL APPLICATION :

- Suitable for welding stainless steels extra low carbon or stabilised by Titanium or Niobium such as AISI grades 317L and 318, S.S. clad pleas, chemical plants, pain and dye industries.
- For welding stainless steel represented by AISI grades 316L, 317L & 318.

Ferrite content in the weld metal : 3 to 9 FN

REDRYING : 250°C / 2 hrs., max 5 cycles, 10 hr. total.

WELD METAL ANALYSIS (RANGE) % :

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.04 max	0.50-2.50	0.9 max	0.03 max	0.04 max	18.0-20.0	12.0-14.0	3.0-4.0	0.75 max

MECHANICAL PROPERTIES (RANGE) :

Ultimate Tensile Strength MPa	Yield Stress MPa	Elongation (%) (L=4D)	Impact Value	
520 min	400-500	30-40	Temp	Joules
			27°C	70-120

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS AC/DC(+)	PACKING PER BOX (Pcs)	WEIGHT / 1000 Pcs (Kg)
2.50	350	60-80	100X5=500	20.50
3.15	350	80-110	60X5=300	33.0
4.00	350	110-140	40X5=200	52.0
5.00	350	140-180	25x5=125	82.0