

# GETIG 317

## IDENTIFICATION

Getig 317, ER 317

## CLASSIFICATION

AWS/SFA 5.9: ER 317

## DESCRIPTION

A stainless steel tig rod intended for welding of low carbon, molybdenum alloyed, acid resisting austenitic stainless steel of similar composition (317). The deposited weld metal is of X-ray quality. The higher molybdenum content provides better resistance to both acid corrosion and pitting corrosion compared to 316L stainless steel grade.

## CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	S	Cr	Ni	Mo	Cu
0.08 max	1.2 - 2.50	0.30 - 0.65	0.03 max	18.5 - 20.5	13.0 - 15.0	3.0 - 4.0	0.75 max

## MECHANICAL PROPERTIES (RANGE)

TS (MPa )	EL (%) (L=4D)
550 min	45 min

## TYPICAL APPLICATIONS

- For welding ASTM / ASME 317 CF8M, DIN 1.4404 / 1.4401, 1.4403, 1.4436.
- Fabrication of stainless steel structures and assemblies such as plate, pipe work, vessels, tanks, forgings and castings, in the chemical power and pharmaceutical industries, food, drink and paper processing plant.

**SHIELDING GAS :** Pure Argon : 99.99% -> 8-16 l/min + back purging

## CORROSION RESISTANCE

Good resistance to chloride pitting resistance. e.g. sulphurous and sulphuric acids.

## PACKING PARAMETERS

Size (mm)	Length (mm)	Packing / Packet (kg)	Packing / Box (kg)
1.6	1000	5	5 x 4 = 20
2	1000	5	5 x 4 = 20
2.40 / 2.50	1000	5	5 x 4 = 20
3.15 / 3.20	1000	5	5 x 4 = 20