

GFC 317L

IDENTIFICATION

GFC 317L, E317LT1-1/4

CLASSIFICATION

AWS A5.22 E317LT1-1/4

DESCRIPTION

GFC 317L (for all-position operation) is low carbon 18.5% Cr - 13.5% Ni - 3.5% Mo austenitic stainless steel flux cored wire. The typical molybdenum gives improved resistance to pitting and crevice corrosion over grades 308L and 309L, particularly in the presence of chlorides. Manufactured under a quality system certified to ISO:9001 requirements.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	P	S	Cr	Ni	Mo	Cu
0.040 max	0.5 - 2.5	1.0 max	0.030 max	0.030 max	18.0 - 21.0	Dec-14	3.0 - 4.0	0.5 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)
520 min	20 min

TYPICAL APPLICATIONS

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

CHARACTERISTICS ON USAGE:

Generally used with 100% CO₂ shielding gas or mixtures of Ar + 20-25% CO₂. Stable arc transfer and ideal slag removal guarantee that slag comes off easily, creating a smooth and fine bead surface.

PACKING PARAMETERS

Size (mm)	Fillet (HF)		Voltage (OH)		Weight / Spool (kg)
	AMPS DC (+)	VOLTAGE (V)	AMPS DC (+)	VOLTAGE (V)	
1.2	140 - 240	23 - 33	120 - 200	27 - 32	12.5
1.6	200 - 300	27 - 32	Not Recommended		12.5