

GRINOX - 17

IDENTIFICATION

GRINOX 17 E317-16

CLASSIFICATION

AWS/SFA 5.4: E 317-16

DESCRIPTION

A rutile coated stainless steel electrode intended for welding of low carbon, molybdenum alloyed, acid resisting austenitic stainless steel of similar composition (317/317L). 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 grades.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	Cr	Ni	Mo	Cu	P
0.08 max	1.0 - 2.50	0.30 - 0.75	0.025 max	18.0 - 21.0	12.0 - 14.0	3.0 - 4.0	0.75 max	0.03 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	EL (%) (L=4D)
550 min	30 - 40

TYPICAL APPLICATIONS

For welding ASTM/ASME 317/317L, 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 pharmaceuticals industries, food, drink and paper processing plant.

CORROSION RESISTANCE

Good resistance to general and intergranular corrosion in most inorganic and organic acids eg: Sulphurous a Sulphuric acids. Good resistance to Chloride pitting resistance.

MICROSTRUCTURE : Austenitic with 3 to 7 FN (3-8% Ferrite) Typical 6 FN

ASME IX QUALITIFICATION : QW-432 F-Number 5, QW-442-A-Number 8

REDRYING : 300°C / 2 hrs, max 5 cycles, 10 hr. total.

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS AC / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	50 - 75	2 x 5 = 10	94 x 5 = 470

	350	80 - 120	$2 \times 5 = 10$	$60 \times 5 = 300$
4	350	100 - 160	$2 \times 5 = 10$	$38 \times 5 = 190$
5	350	130 - 210	$2 \times 5 = 10$	$24 \times 5 = 120$