

GRITINOX 317L

IDENTIFICATION

GRITINOX 317L E317L-17

CLASSIFICATION

AWS/SFA 5.4: E317L-17

DESCRIPTION

A titania coated 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 800°C and stress corrosion cracking. Molybdenum imparts resistance to corrosion of reducing nature. The deposited weld metal is of radiographic quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.04 max	0.50 - 2.50	1.0 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)

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
520 min	30 min	27°C	70 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.

FERRITE CONTENT IN THE WELD METAL : 3 to 9 FN

REDRYING : 250°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	60 - 80	2 x 5 = 10	94 x 5 = 470
3.15 / 3.20	350	80 - 110	2 x 5 = 10	60 x 5 = 300
4	350	110 - 140	2 x 5 = 10	38 x 5 = 190
5	350	140 - 180	2 x 5 = 10	24 x 5 = 120