AUTOTHERME-317L

CODIFICATION: AWS/SFA 5.9 ER317L

CHARACTERISTICS AND APPLICATIONS:

Autotherme 317L is a solid wire for MIG / TIG welding, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality weld deposit. It is ideally suited for welding of stainless steels of similar composition and their equivalents. Low carbon weld metal increases the resistance to intergranular corrosion. It is also excellent resistance against Sulfuric, Sulfurous and phosphoric acids.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Cr	Ni	Mo
Percent	0.025	1.20	0.40	0.015	0.018	19.5	14.0	3.5

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L = 5d) %
540	35.0

SHIELDING GAS: Argon

CURRENT CONDITIONS: DCEP (MIG) / DCEN (TIG)

WELDING POSITIONS: H, F, VU, OH

PACKING:

STANDARD SIZE: Diameter 0.8 mm, 1.2 mm & 1.6 mm

QUANTITY 12.5 kgs wire, layer wound in a plastic spool that conforms to DIN 8559 SD-300.