Technical data sheet 011121MBA	Cored welding wire # TETRA V 317L-G	Welding Alloys

CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22:	E317LT1-4 - E317LT1-1
EN ISO 17633-A:	T Z 19 13 4 L P M21 1 / T Z 19 13 4 L P C1 1
EN ISO 17633-B :	TS317L-F M21 1 / TS317L-F C1 1
Equivalent Material number :	1.4438
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Rutile flux cored stainless steel wire for gas shielded arc welding
- 19% chromium - 12% nickel - 3.5% molybdenum - low carbon deposit
- Attractive bead appearance, very good penetration and high productivity
- Excellent X-ray soundness
- Specifically designed for out-of-position welding
- Maximum productivity for completion of vertical welds
- Welded with classical economic Ar-CO_2 mixtures or CO_2

APPLICATIONS

TETRA V 317L-G is suitable for welding stainless steels with an alloy content between 16 to 21% Cr, 10 to 15% Ni and up to 3% Mo, stabilised and unstabilised types where enhanced resistance to pitting and acid corrosion is required.

Examples:

AISI	UNS	Material number	EN Symbol
316	S31600	1.4401	X5 CrNiMo 17-12-2
316L	S31603	1.4404	X2 CrNiMo 17-13-2
316Ti	S31635	1.4571	X6 CrNiMoTi 17-12-2
317	S31700	1.4449	X3 CrNiMo 18-12-3
317L	S31703	1.4438	X2 CrNiMo 18-15-4
318	S31640	1.4583	X10CrNiMoNb 18-12

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	S	P
0.03	1.40	0.80	19.5	13.0	3.50	0.008	0.020

Typical ferrite level: 7 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A_5 [%]	CVN [J]
520	350	20	-60°C: 27

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]
620	510	30	-60°C: 40

SHIELDING GAS

M21 (Ar + 15 - 25% CO_2), M20 (Ar + 5%< CO_2 ≤ 15%) gas mixtures or C1 (CO_2) according to EN ISO 14175

OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow rate
1.2	DC+	100 - 270	22 - 35	12 - 25	10 - 20 l/min.

WELDING POSITIONS

All positions

PACKAGING

Diameter	1.2 mm	
	EN ISO 544 – ASME IIC SFA-5.2 M	
Spool type	S200	BS300
Weight	5 kg	15 kg

Other packaging and other diameters: please consult us