

Stick Electrode for Stainless Steel

KS-317

Classification

AWS	A 5.4	E317-16
JIS	Z3221	ES317-16
EN	3581-A	—
GB	T 983	E317-16

Type of coating: Lime titania type

Applications and Features

- (1) Weld metal is 19%Cr-12%Ni-3%Mo.
- (2) It provides good corrosion, pitting and heat resistance to sulfuric and sulphurous acid due to its high Mo content.
- (3) It is ideal for welding critical chemical vessels.

Welding Position

All Positions

Welding Instruction

- (1) Please refer to Appendix H for re-drying instructions.
- (2) For other instruction information, please refer to Appendix F.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S	Cr	Ni	Mo
0.060	0.33	1.52	0.015	0.010	19.42	12.85	3.48

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	5% Sulfuric Acid
N/mm ² (kgf/mm ²)	N/mm ² (kgf/mm ²)	%	Corrosion Test (g/m ² hr)
590(60.2)	430(43.8)	41	≤6

Size and Suggested Operating Range (AC or DC+)

Diameter x Length (mm)	2.0x250	2.6x300	3.2x350	4.0x350	5.0x350	
Amp	F/H-Fillet	35~55	50~85	80~120	100~150	140~200
	V-up/OH	30~50	45~85	70~110	90~135	—