

Stick Electrode for Stainless Steel

KS-317L

Classification

AWS A 5.4	E317L-16
JIS Z3221	ES317L-16
EN 3581-A	—
GB T 983	E317L-16

Type of coating: Lime titania type

Applications and Features

- (1) Weld metal is 19%Cr-12%Ni-3%Mo, which is suitable for welding AISI 317L steel.
- (2) It provides good corrosion and heat resistance due to its low C and additional Mo content.
- (3) It has good strength at high temperature and post weld heat treatment is not required.
- (4) It is ideal for welding critical chemical vessels for sulfuric and sulphurous acid.

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
0.034	0.36	1.49	0.015	0.010	19.61	13.85	3.52

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)
580(59.1)	430(43.8)	41	≤5

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	—