

Flux Cored Wire for Stainless Steel

KFW-317L

Classification

Shielding gas: CO ₂ or Ar+20%CO ₂	AWS	E317LT1-1/4	—
	JIS	Z3323	TS317L-FB1
	EN	17633-A	T Z 19 13 4 L P M 1
	GB	T17853	E317LT1

Applications and Features

- (1) Weld metal is 19%Cr-13%N-3%Mo, which is suitable for welding AISI 317L steel.
- (2) It provides good corrosion and heat resistance due to low C and additional Mo content.
- (3) It provides good strength at high temperature and no post weld heat treatment required.
- (4) It is ideal for welding critical chemical vessels for sulfuric and sulphurous acid.

Welding Instruction

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

Typical Chemical Composition of Weld Metal (wt %) (Shielding Gas : Ar+2%O₂)

C	Si	Mn	P	S	Cr	Ni
0.025	0.059	1.11	0.021	0.008	19.16	13.11

Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar+2%O₂)

Tensile Strength N/mm ² (kgf/mm ²)	Yield Strength N/mm ² (kgf/mm ²)	Elongation %
560	380	39

Size and Suggested Operating Range (DC+)

Operating range	Diameter (mm)	0.8	0.9	1.0	1.2	1.4	1.6	
		Ar+1~2%CO ₂	Amp	—	60~140	80~160	100~210	—
		Volt	—	15~21	16~22	17~22	—	—
Ar+1~2%O ₂	Amp	—	170~260	180~280	200~300	210~320	220~330	
	Volt	—	24~30	24~30	24~30	24~32	24~32	