UP 317L

S.S. SAW Wire

Selectarc

FSH WELDING GROUP

INNOVATIVE WELDING CONSUMABLES

www.fsh-welding.com

Classification

AWS A 5.9: ER317L EN ISO 12072 19 13 4L

Characteristics

UP 317L is designed for welding type 18Cr 14 Ni3 Mo austenitic stainless steels and similar. The enhanced content of Chromium, Nickel and Molybdnum in comparison with 316L gives even better corrosion resistance to general, pitting and inter crystalline corrosion. Primary in acid chloride containing environments. Austenitic deposit with 5-10% Ferrite.

Application

For the fabrication of dilute hot acids storage tank. Equipment used in corrosive environments, Piping, etc….

NF	EN	ASTM
Z3 CND 19-15-04 Z3 CND 18-14-05 Az	1.4438 1.4439	317L 317LMN

Wire Analysis % (Typical)

C	Mn	Si	Cr	Ni	Mo	P	S
0,02	1,60	0,35	19.50	13.25	3.60	0,015	0,008

Mechanical properties of the pure weld metal (Typical)

Flux	Heat-treatment	YS $R_{p0.2}$ MPa	UTS R_m MPa	% Elgn. A_5	Charpy V Notch [J] + 20°C	Charpy V Notch [J] - 196°C
INOX L / UP WP 380M	AW	440	590	36	70	35

AW: as welded

Inter pass Temperature : < 150 °C . Heat Input <1.5kJ/mm. No heat treatment required after welding, however in special cases quench annealing at 1050 °C.

current/polarity

= +

Diameters: Ø 2.0 – 4.0mm