

CODIFICATION: AWS/SFA 5.9: ER317 L

CHARACTERISTICS AND APPLICATIONS:

FW 317L is a solid wire for TIG welding, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality welds. It is ideally suited for welding of stainless steels of similar composition and their equivalents. Low carbon weld metal increases the resistance to intergranular corrosion. It is also excellent resistance against Sulfuric, Sulfurous and phosphoric acids.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Cr	Ni	Mo
Percent	0.025	1.20	0.40	0.015	0.018	19.5	14.0	3.5

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L=4d) %
540	35

SHIELDING GAS : Argon

CURRENT CONDITIONS : DCEN

WELDING POSITION : H, F, VU, OH

PACKING:

STANDARD SIZE	Diameter 1.6 mm 2.0 mm, 2.50 mm & 3.20 mm in cut lengths of 1000 mm each.
QUANTITY	5 kgs wire put in an air-tight polythene bag and finally packed in a plastic container. Identification – AWS code is punched on both the sides of wire.

An ISO 9001: 2008 certified company

D & H Sécheron Electrodes Pvt. Ltd.

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