

# SW-317L Cored

Type : Rutile

## Conformances

AWS A5.22/ ASME SFA5.22 E317LT1-1/-4

JIS Z3323 TS317L-FB1

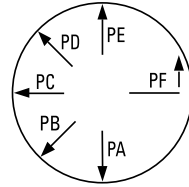
## Applications

- 316, 317 type stainless steels

## Features

- Good performance in all positions

## Welding Position



## Current

DC +

## Shielding Gas

100% CO<sub>2</sub>

Ar + 20~25% CO<sub>2</sub>

## Diameter / Packaging

Diameter mm (in)	Spool			Pac		
	5kg (11lbs)	12.5kg (27.6lbs)	15kg (33lbs)	250kg (551lbs)	300kg (661lbs)	350kg (771lbs)
0.9 (0.035)	✓	✓	✓			
1.0 (0.040)	✓	✓	✓			
1.2 (0.045)	✓	✓	✓			
1.6 (1/16)		✓	✓			

**Typical Chemical Composition of All-Weld Metal (%)**

	C	Si	Mn	P	S	Cr	Ni	Mo
100% CO <sub>2</sub>	0.029	0.61	1.41	0.022	0.007	18.71	12.40	3.17
80% Ar + 20% CO <sub>2</sub>	0.028	0.67	1.55	0.022	0.007	18.90	12.55	3.25

**Typical Mechanical Properties of All-Weld Metal**

	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)
100% CO <sub>2</sub>	585 (84,825)	36.8	-60 (-76)	32 (23.6)
80% Ar + 20% CO <sub>2</sub>	595 (86,275)	35.4	-60 (-76)	31 (22.8)

**Typical Welding Parameters**

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
<b>1.2mm (0.045 in) DC+</b>					
100% CO <sub>2</sub>	20 (4/5)	6.0 (236)	140	23-26	2.5 (5.5)
		8.9 (350)	180	27-30	3.4 (7.5)
		12.0 (472)	210	28-31	4.5 (9.9)
80% Ar + 20% CO <sub>2</sub>	20 (4/5)	6.0 (236)	140	23-26	2.6 (5.7)
		9.0 (354)	180	27-30	3.5 (7.7)
		11.5 (453)	210	27-30	4.5 (9.9)
<b>1.6mm (1/16 in) DC+</b>					
100% CO <sub>2</sub>	25 (1)	3.8 (150)	180	24-27	3.1 (6.8)
		6.5 (256)	250	25-28	4.6 (10.1)
		8.9 (350)	290	26-29	6.0 (13.2)
80% Ar + 20% CO <sub>2</sub>	25 (1)	3.7 (146)	180	24-27	3.2 (7.1)
		6.4 (250)	250	25-28	4.8 (10.6)
		9.0 (354)	290	26-29	6.2 (13.7)

SWAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX