



Tech-Rod 317L

Description

The weld deposit of Tech-Rod 317L is similar to that of type 317, except the carbon content is limited to a minimum of 0.04%. In addition to the resistance to pitting and crevice corrosion, the deposit made with this consumable offers good resistance to inter-granular corrosion.

Specifications & Approvals

AWS A5.4 E317L-16

UNS W31713

CWB

ASME QSC-395

Typical Chemical Composition

C	Mn	Si	Fe	Cr	Mo	Ni	Nb	N	S	P	Cu	FN
.035	1.65	.55	BAL	18.75	3.40	13.00		*	.019	.022		7

* Nitrogen in these weld deposits is usually between .04% and .08%

Typical Mechanical Properties

Tensile Strength	82,500 PSI	570 MPA
Yield Strength	58,000 PSI	400 MPA
Elongation	38%	

Welding Parameters

Process	Diameter x Length	Voltage	Amperage	
			Flat	Vertical & Overhead
SMAW	3/32" (2.4mm) x 12" (305mm)	24-28	70-85	65-75
	1/8" (3.2mm) x 14" (355mm)	26-30	85-110	80-90
	5/32" (4.0mm) x 14" (355mm)	28-32	110-140	100-120
	3/16" (4.8mm) x 14" (355mm)	28-32	120-160	110-130

Standard Packages:

3/32" Diameter	8 Lb (3.6Kg) Can	24 Lb (10.9Kg) Master Carton	26 Electrodes per Lb
1/8" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	14 Electrodes per Lb
5/32" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	9 Electrodes per Lb
3/16" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	6 Electrodes per Lb