

ER317L

TIG (GTAW)

SOLID WIRE FOR TIG

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PRODUCT DESCRIPTION

Solid wire for TIG welding.

CLASSIFICATIONS

AWS A5.9M ER 317, ER 317L
ISO 14343-A W 19 13 4 L
ISO 14343-B SS317, SS317L

ASME IX QUALIFICATION

QW432 F-No 6
QW442 A-No 8

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	FN
Min.	--	1.0	0.30	--	--	18.5	13.0	3.0	--	2
Max.	0.03	2.5	0.65	0.02	0.030	20.0	15.0	4.0	0.3	10
Typical	0.015	1.5	0.4	0.01	0.02	19	14	3.5	0.15	5

ALL-WELD MECHANICAL PROPERTIES

As welded	Typical
Tensile strength (MPa)	630
0.2% proof strength (MPa)	450
Elongation (%) 4d	35
Impact ISO-V(J) +20°C	75

TYPICAL OPERATING PARAMETERS

Shielding	Current	Diameter (mm)	Parameters
Argon*	DC-	2.4	100A, 12V

*Also required as a purge for root runs.

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.6	5	PE TUBE	TER317L-16
2.4	5	PE TUBE	TER317L-24