

❖ Product Description

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| I. Low carbon steel alloy wire | IV. The weld metal is of controlled ferrite & withstand working temp up to 300°C |
| II. Resistant to intergranular corrosion with no need of use of stabilizer | V. Resistance to scale upto 300°C |
| III. Free from porosity and molten pool | VI. Radiographic weld quality |

❖ Range of Application

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| I. For welding AISI 317, ASME 317L type of plate sheet | III. Excellent for root run |
| II. For welding pipes and tubes for chemical, pharmaceutical, dairy & fertilizer, Industries, oil refineries | |

❖ Classification

- AWS/SFA 5.9 ER317-L

❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	Cr	Cu	Mo	P	Ni
ER317-L	Min	-	1.0	-	0.30	18.5	-	2.0	-	13.0
	Max	0.03	2.5	0.03	0.65	20.5	0.75	3.0	0.03	15.0

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charpy "v" Notch Impact @ -30°C
As Welded	520	-	30	-

❖ Wire Size & Welding Position

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| • Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60 | • Weld Position- All position |
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❖ Current & Gas Flow

- DCEP; 15-22lit/min

❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60								
Packing Code	A	B	C	D	E	F	G	H	I
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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