



Techalloy 317L

Description

Techalloy 317L is used for welding stainless steels with similar composition or 316/316L type materials. Due to its higher molybdenum content, this alloy offers high resistance to pitting and crevice corrosion. Low carbon makes the weld metal less susceptible to inter-granular corrosion.

Specifications & Approvals:

AWS A5.9 ER317L

UNS S31783

ISO 14343:2009 (18 15 3 L)

CWB

Typical Chemical Composition

C	Mn	Si	Cr	Mo	Ni	Nb	N	S	P	Cu	FN (WRC)
.017	1.66	.44	19.40	3.25	13.85			.006	.012		6

Typical Mechanical Properties

Tensile Strength	84,500 PSI	580 MPA
Yield Strength	58,000 PSI	400 MPA
Elongation	35%	

Welding Parameters

	Shielding	Gas Flow	Diameter	Voltage	Amperage
Mig Welding	98/99% Argon + 2/1% Oxygen 97% Argon + 3% CO2	30 to 50 CFH	.035" (0.9mm)	26 to 29	160/210
			.045" (1.14mm)	28 TO 32	180/250
			.062" (1.6mm))	29 TO 33	200/280
Tig Welding	100% Argon				
Sub Arc Welding	Suitable flux may be used		3/32" (2.5mm)	28 to 33	275/350
			1/8" (3.14mm)	29 TO 32	350/450
			5/32" (4.0mm)	30 TO 33	400/550

Standard Packages:

Mig Wire– 33# wire basket	Tig Wire– 10# tube/30# Master Carton	SAW– 60# Coil
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