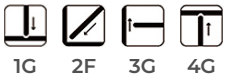
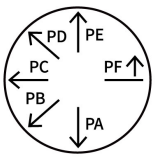
SW-317L Cored

Classification

AWS AWS A5.22/ ASME SFA-5.22 E317LT1-1/-4
JIS Z 3323 TS317L-FB1
EN ISO 17633-A-T 19 13 4 P M21/C1 2

Welding Positions





Features

- Good performance in all positions

Polarity

DC +

Application Areas

- 316, 317 type stainless steels

Shielding Gas

100% CO2
Ar+20~25% CO2

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

Shielding Gas	C	Si	Mn	P	S	Cu	Ni	Cr	Mo
100% CO2	0.03	0.6	1.5	0.022	0.007	0.07	12.4	18.7	3.2
Ar + 20% CO2	0.03	0.6	1.6	0.022	0.007	0.07	12.5	18.9	3.2

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
100% CO2	585(85)	36	-20(0)	36(27)
Ar+20~25% CO2	595(86)	35	-20(0)	35(26)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2 (0.045)	160~220	Spool 5kg(11lbs), 12.5(27.6lbs), 15kg(33lbs)
1.6 (1/16)	250~290	