

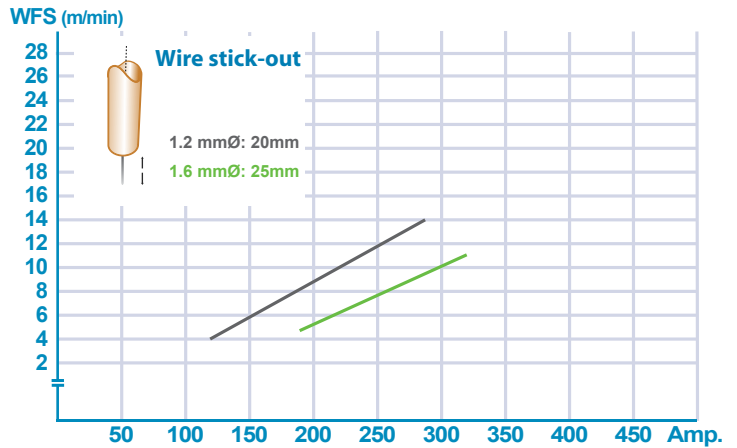
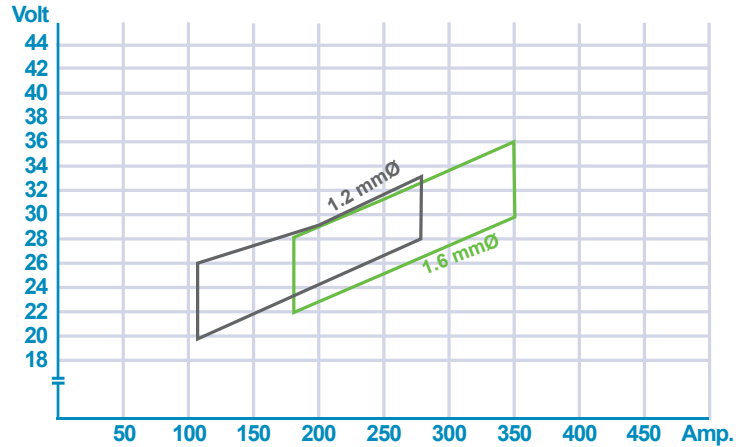
80%Ar - 20%CO₂ / 100%CO₂
 EN ISO 17633-A TZ 19 13 4 L R C/M 3
 AWS A5.22 E317LT0-1/4
 EN 1.4440

Description and Application

This is a rutile flux cored wire which operates with very stable, spatter free arc producing bright, smooth weld bead surfaces and self releasing slag.

PREMIARC™ DW-317L is designed for welding 18%Cr-12%Ni-2.5%Mo-N (type 316LN) or 19%Cr-12%Ni-3.5%Mo (type 317L) stainless steels. Due to the low carbon contents in the weld metal, it is possible to obtain high resistance to intergranular corrosion.

Recommended Parameter Range, for flat position



Typical Chemical Analysis (wt. %)

C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.03	0.60	1.10	0.02	0.008	12.6	19.1	3.5	-	-	9.2	11.6	8.7

Typical Mechanical Properties

	R _c (MPa)	R _m (MPa)	A ₅ (%)	CV (J) 0°C
	490	620	35	50
Guarantee	min.350	min.550	min.25	

Welding Positions



Approvals

LR	DNV	BV	GL	ABS	R.M.R.S	Others
-	317L	-	-	-	-	-