Inweld 317L

AWS A5.9 ER 317L

Chemical Composition of Inweld 317L

C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu	Fe
0.3	18.5-20.5	13.0-15.0	3.0-4.0	1.0-2.5	0.30-0.65	0.03	0.03	---	0.75	Balance

Single values are maximum unless otherwise specified.

Description and Applications

The classification is the same as ER317, except for the carbon content. Low carbon (0.03% maximum) in this filler metal reduces the possibility of intergranular carbide precipitation. This increases the resistance to intergranular corrosion without the use of stabilizers such as niobium or titanium. This low-carbon alloy, however may not be as strong at elevated temperature as the niobium-stabilized alloys or Type 317

Procedure

Typical Weld Metal Properties

	AWS Spec (ksi)
Average As-Welded Hardness:	
Tensile Strength:	
Yield Strength:	
Elongation:	

Recommended Parameters

Wire Diameter	Voltage	Amperage