

SW-317L Cored

AWS A5.22/ASME SFA5.22 E317LT1-1/-4
JIS Z3323 TS317L-FB1

TYPE : Rutile

Applications

SW-317L Cored is designed for the welding of low carbon 18%Cr-12%Ni-2% Mo and 19%Cr-13%Ni-3%Mo stainless steels.

Characteristics on Usage

SW-317L Cored is a flux cored wire for all position welding to be used with CO₂ or Argon + CO₂ mixed shielding gases.

Due to ferrite contents in the weld metals austenitic structure, it has excellent crack resistance.

Notes on Usage

① Use with 100% CO₂ or Ar + 20~25% CO₂ gas.

Welding Position



1G (PA) 2F (PB) 3G (PF) 4G (PE)

Current

DC +

Shielding Gas

CO₂/Ar+20~25%CO₂

Typical Chemical Composition of All-Weld Metal (%) (Shielding Gas: 100% CO₂)

C	Si	Mn	P	S	Cr	Ni	Mo
0.03	0.70	1.20	0.025	0.010	19.0	13.0	3.5

Typical Mechanical Properties of All-Weld Metal (Shielding Gas: 100% CO₂)

TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
600 (87,000)	35	-20 (-4)	40 (30)

Approval

I Packing(Including Ball Pac)

Dia. (mm)	0.9	1.2	1.6	Spool(kg)	5	12.5	15
(in)	.035	.045	1/16	(lbs)	11	28	33

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	0.9 (.035)	1.2 (.045)	1.6 (1/16)
F & HF	130~180	180~220	250~290
V-up,OH	100~140	120~160	-