

**Classifications**

|             |            |
|-------------|------------|
| AWS A5.4-06 | : E317-16  |
| KS D 7014   | : E317-16  |
| JIS Z 3221  | : ES317-16 |

**Description**

- Covering is lime titania type for welding of AISI 317 or dissimilar steels such as carbon steel to stainless steels.
- Good weldability and performance.
- Reduce the susceptibility of pitting.
- Redry the electrode at 250~350°C for 30~60 minutes prior to use.

**Welding positions****Typical chemical composition of all-weld metal (%)**

| C    | Si   | Mn   | P     | S     | Ni    | Cr    | Mo   | Cu   |
|------|------|------|-------|-------|-------|-------|------|------|
| 0.06 | 0.74 | 1.20 | 0.026 | 0.007 | 12.34 | 18.57 | 3.20 | 0.15 |

**Typical mechanical properties of all-weld metal**

|            | Y.S (0.2%OS)<br>(MPa) | T.S<br>(MPa) | El.<br>(%) | Remarks |
|------------|-----------------------|--------------|------------|---------|
| AWS A5.4   |                       | min. 550     | min. 30    |         |
| JIS Z 3221 |                       | min. 550     | min. 20    |         |
| Example    | 450                   | 580          | 43         | AW      |

\* AW : As-Welded

**Sizes available and recommended currents (AC or DC +)**

| Dia.        | (mm)        | 2.0            | 2.6            | 3.2             | 4.0               | 5.0          |
|-------------|-------------|----------------|----------------|-----------------|-------------------|--------------|
| Length      | (mm)        | 250            | 300            | 350             | 350               | 350          |
| Amp.<br>(A) | F<br>V · OH | 40~60<br>35~45 | 55~90<br>45~60 | 80~110<br>70~90 | 110~150<br>90~130 | 140~180<br>- |