

# S-317L.16

TYPE : Rutile

AWS A5.4 / ASME SFA5.4 E317L-16  
JIS Z3221 ES317L-16

SMW

## Applications

Welding of 317L stainless steel.

## Characteristics on Usage

Lime-titania type, for all-position welding, good usability.

All-weld metal has a low carbon austenite structure composed of 18%Cr-12%Ni-3.5%Mo.

Owing to the large contents of Mo, all-weld metal has a good resistance to corrosion in deoxidizing atmosphere containing nitroxide and sulfide.

## Notes on Usage

- ① Keep the current as low as possible and arc length as short as possible.
- ② Dry the electrodes at 350°C(662°F) for 60 minutes before use.
- ③ Remove foreign substance such as oil or scale from the groove.

## Welding Position

## Current



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

AC or DC +

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

C	Si	Mn	P	S	Cr	Ni	Mo
0.02	0.63	1.05	0.029	0.018	18.3	12.6	3.2

## Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in <sup>2</sup> )	EL (%)
588 (85,400)	38.4

## Approval

## I Packing

Packet 2.5 kg (5.5 lbs)  
Carton 2.5 kg (5.5 lbs) × 4 : 10kg(22 lbs)

## Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.0 (5/64)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm(in)	300 (12)	300 (12)	350 (14)	350 (14)	350 (14)
F	25~55	50~85	70~115	95~150	135~180
V-up, OH	20~50	45~80	65~110	85~135	-