

**selectarc**



**317L-16**

AC/DC+

**STAINLESS STEEL**

**DESCRIPTION**

Rutile coated stainless steel 317L-16 type electrode designed for all position welding of Cr-Ni-Mo stainless steel grades (316, 316L, 317, 317L, 318, etc.)

**CLASSIFICATION** AWS A5.4 : E317L-16

**TYPICAL APPLICATIONS**

Welding of Cr-Ni-Mo steels for chemical plant, petroleum plants, refineries and pulp and paper, etc. Tanks, pipes, heat exchangers, etc.

**BASE MATERIALS** 316, 316L, 317, 317L, 318, etc

**PROCEDURE**

Clean welding area. Keep a short arc with the electrode slightly inclined or always in contact with the part. Remove flux between each pass. Use only dry electrode.

**MECHANICAL PROPERTIES**

Tensile strength: > 87 000 psi (> 600 MPa)  
 Yield strength: > 70 000 psi (> 480 MPa)  
 Elongation: > 35 - 37 %

**TYPICAL WELD METAL COMPOSITION (%)**

C	Cr	Ni	Mo	Mn	Cu
0.04	18.0 - 21.0	12.0 - 14.0	3.0 - 4.0	0.5 - 2.5	0.75

**WELDING PARAMETERS**

Diameter: 4.0 mm (5/32") 3.2 mm (1/8") 2.5 mm (3/32")  
 Amperage: 130 A 100 A 70 A

Rév. :7\_01

*Specialized welding alloys and technology. For technical assistance or for ordering:*



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