Product Data Sheet

W 'Tungsten inert gas arc welding'

OK Tigrod 317L

Signed by	Approved by	Reg no	Cancelling	Reg date	Page
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REASON FOR ISSUE

Shielding Gas standard up date.

GENERAL

Bare corrosion resisting chromium-nickel-molybdenum welding rods for welding of austenitic stainless alloys of 19% Cr 9% Ni 3% Mo types.

OK Tigrod 317L has a good resistance to general corrosion and pitting due to its high content of molybdenium. The alloy has a low carbon content which makes this alloy particularly recommended were there is a risk of intergranular corrosion. The alloy is used in severe corrosion conditions such as in the petrochemical , pulp and paper industries.

Shielding Gas: I1 (EN ISO 14175)

Alloy Type: Austenitic (with approx. 8 % ferrite) 19% Cr - 12% Ni - 3% Mo - Low C

CLASSIFICATIONS Wire Electrode

EN ISO 14343	W 18 15 3 L
SFA/AWS A5.9	ER317L

APPROVALS

Not applicable

CHEMICAL COMPOSITION

Wire/Strip (%)

	Min	Max
C		0.03
Si	0.30	0.65
Mn	1.4	2.2
P		0.030
S		0.020
Cr	18.5	20.0
Ni	13.0	15.0
Mo	3.0	4.0
Cu		0.30
Others tot		0.50

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

	As welded	
Properties	**Min**	**Typ**
Rp0.2 (MPa)	300	390
Rm (MPa)	480	600
A4-A5 (%)	25	45
Charpy V at 20°C (J)		135
Charpy V at -196°C (J)		55