

## Exaton E317LT1-4/1

FCAW wire for 18%Cr - 12%Ni – 3% Mo- N stainless steel For all-position welding. Recommended for welding type 317 stainless steel to give a maximum of 0.04% carbon in the weld deposit. The higher molybdenum content, as compared to type 316L, further reduces susceptibility to pitting corrosion. Used in the pulp and paper industry and in other severe corrosion applications involving sulfuric and sulfurous acids and their salts.

### Specifications

<b>Classifications</b>	SFA/AWS A5.22 : E317LT1-1(4) JIS Z 3323 : YF317LC KS D 3612 : YF317LC
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<b>Welding Current</b>	DC+
<b>Alloy Type</b>	C Cr Ni Mo
<b>Shielding Gas</b>	M21, C1 (EN ISO 14175)

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>M21 Shielding gas</b>			
As Welded	480 MPa	620 MPa	35 %
<b>C1 Shielding Gas</b>			
As Welded	460 MPa	600 MPa	34 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>C1 Shielding Gas</b>		
As Welded	-29 °C	47 J
As Welded	-196 °C	20 J

### Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo
<b>M21 Shielding gas</b>							
0.032	1.20	0.85	0.009	0.021	13.0	19.50	3.50
<b>C1 Shielding Gas</b>							
0.032	1.20	0.80	0.009	0.021	12.5	18.4	3.40