Exaton 317/317L T1

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	
Classifications	SFA/AWS A5.22 : E317LT1-1(4) JIS Z 3323 : YF317LC KS D 3612 : YF317LC

Welding Current	DC+
Alloy Type	C Cr Ni Mo
Shielding Gas	M21, C1 (EN ISO 14175)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
M21 Shielding gas			
As Welded	480 MPa (70 ksi)	620 MPa (90 ksi)	35 %
C1 Shielding Gas			
As Welded	460 MPa (67 ksi)	600 MPa (87 ksi)	34 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
C1 Shielding Gas		
As Welded	-29 °C (-20 °F)	47 J (35 ft-lb)
As Welded	-196 °C (-321 °F)	20 J (15 ft-lb)

Typical Weld Metal Analysis %							
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**
M21 Shielding gas							
0.032	1.20	0.85	0.009	0.021	13.0	19.50	3.50
C1 Shielding Gas							
0.032	1.20	0.80	0.009	0.021	12.5	18.4	3.40