

Exaton 19.13.4.L (GMAW)

19.13.4.L is suitable for joining stainless CrNiMo steels e.g. 317L or similar. It is used for MIG/MAG welding.

Specifications

Classifications

EN ISO 14343-A : G 19 13 4 L
 SFA/AWS A5.9 : ER317L
 Werkstoffnummer : 1.4438*

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	380 MPa	600 MPa	42 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C	140 J

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
<=0.02	1.5	0.4	<=0.020	<=0.020	14	19	3.6	<=0.3

Recommended Welding Parameters

Current	Wire Diameter	Voltage	Wire Feed Speed
150-260 A	1.2 mm	24-29 V	3.0-10.0 mm/min