

DESCRIPTION

Executive 317L wire is designed to provide clean and consistent welds with excellent feedability and minimal clean-up. By maintaining tight control from the country of melt to the design of the spool Executive wire provides welders with the highest quality stainless bare wire.

Executive 317L has an increased molybdenum content which gives it a superior resistance to highly corrosive environments.

APPLICATIONS & FEATURES

Executive 317L is used in petrochemical environments, chemical processing, pressure piping, vessel manufacturing, and general manufacturing and fabrication.

Executive 317L has a maximum carbon level of 0.03% which enhances the resistance to intergranular corrosion.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N	
0.012	18.83	13.56	3.55	1.34	0.41	0.020	0.013	0.12	0.058	
Tensile Strength:		85,600 PSI min		Elongation:		43%		Ferrite Range:		7.1 FN (WRC-92)
Yield Strength:		60,900 PSI min								

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux	
GMAW - Short	.035"	21-22	160-200	30 to 50 CFH	90% He/7.5% Ar/2.5% CO ₂ or 1%-5% O ₂ /Balance Ar	
	.045"	22-23	180-210			
	.062"	23-24	200-220			
	- Spray	.035"	23-25			190-260
		.045"	25-28			250-330
		.062"	28-31			310-350
GTAW	.062" - .125"	Direct Current; Electrode -		30 to 40 CFH	100% Ar	
SAW	.093"	29-32	300-350		Record IND 24 or Record IN	
	.125"	29-32	400-550			

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	1,980-lb pallet
	11-lb plastic spools	11-lb box
	2-lb plastic spools	8-lb box
GTAW (TIG)	10-lb plastic tube	40-lb box
SAW	60-lb wire coil	1,200-lb pallet



CLASSIFICATION

AWS/SFA 5.9, Class **ER317L**
Certified by the Canadian Welding Bureau (CWB) to AWS A5.9.