

#### 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	
<b>Tensile Strength:</b>		85,600 PSI min		<b>Elongation:</b>		43%		<b>Ferrite Range:</b>		7.1 FN (WRC-92)
<b>Yield Strength:</b>		60,900 PSI min								

#### TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux
<b>GMAW</b> - Short - Spray	.035"	21-22	160-200	30 to 50 CFH	98% Ar / 2% O <sub>2</sub>
	.045"	22-23	180-210		
	.035"	23-25	190-260		90% Ar / 10% O <sub>2</sub>
	.045"	25-28	250-330		
<b>GTAW</b>	.093"	Direct Current; Electrode -		30 to 40 CFH	100% Ar
<b>SAW</b>	.093"	29-32	300-350		Record IN Flux
	.125"	29-32	400-550		

#### STANDARD PACKAGING

<b>GMAW</b> (MIG)	33-lb wire baskets	1,980-lb pallet
	11-lb plastic spools	11-lb box
	2-lb plastic spools	8-lb box
<b>GTAW</b> (TIG)	10-lb plastic tube	40-lb box
<b>SAW</b>	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.