EXECUTIVE 317/317L

STAINLESS STEEL
SOLID WIRE TECHNICAL DATA SHEET

DESCRIPTION

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

APPLICATIONS & FEATURES

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

Executive 317/317L has a maximum carbon level of 0.03% which enhances the resistance to intergranular corrosion. This wire is also suitable for laser welding and WAAM applications (Wire Arc Additive Manufacturing, aka Metal 3D printing).

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		
		.045"	22-23	180-210		90% He/7.5% Ar/2.5% CO_2
		.062"	23-24	200-220	30 to 50 CFH	or
	- Spray	.035"	23-25	190-260		1%-5% O_2/Balance Ar
		.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 **ER317/317L**
Certified by the Canadian Welding Bureau (CWB) to AWS A5.9.