

DESCRIPTION

Executive 317/317L provides superior weldability, low spatter and smooth beads with easy slag removal. Weld metal is suitable for welding AISI 317L Steel. It provides good corrosion and heat resistance due to its low C and additional Mo content.

The alloy content of weld metal deposited by these electrodes is somewhat higher than that of Exocor 316L electrodes, particularly in molybdenum. These electrodes are usually used for welding alloys of similar composition and are utilized in severely corrosive environments (such as those containing halogens) where crevice and pitting corrosion are of concern.

APPLICATIONS & FEATURES

Good strength at high temperatures and post weld heat treatment is not required. Ideal for welding critical chemical vessels for sulfuric and sulphurous acid.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	N
0.039	0.41	1.50	0.033	0.005	20.52	12.62	3.65	0.13	0.07

Tensile Strength:	84,100 PSI min	Yield Strength:	62,400 PSI min	Elongation:	41%
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TYPICAL WELDING PARAMETERS

Process	Diameter	Length	Amperage
SMAW AC/DC	3/32"	12"	40-70
	1/8"	14"	60-100
	5/32"	14"	90-140
	3/16"	14"	120-185

STANDARD PACKAGING & HANDLING

SMAW	40-lb master box
	10-lb plastic tube

CLASSIFICATION

AWS/SFA 5.4, Class **E317/317L-16**

