

Shielded Metal Arc Welding

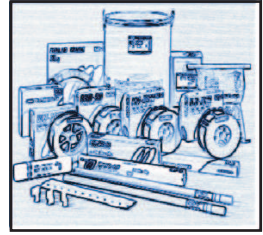
ANU BOND - 317L (E317L - 16)

AWS: SFA 5.4, E 317L - 16, IS:5206- E 19.12.3LR 26

Stainless Steel Welding Electrodes

Application :

It is use for welding of AISI 317L type SS plant as well as 316L similar type of material for joining of stainless steel to low alloy and carbon steel. For sever corrosion applications involving sulphuric acid and their salt.



Characteristics :

A medium stainless steel electrode depositing an extra low carbon weld metal containing 19 Cr, 12Ni, and 3 Mo. The weld metal is resistance to inter - crystalline corrosion cracking, hot cracking and chemical corrosion against sulphuric acid etc. The higher molybdenum content reduces the susceptibility to pitting ; improve creep strengths at elevated temp. And practically eliminates cracking as the weld cools form molten stage to room temp. Redry electrodes at 300°C one hour for better results.

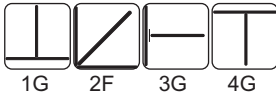
Chemical composition of All-Weld metal (%) as per AWS

C	Mn	Si	P	S	Cr	Ni	Mo	Cu
0.040 Max	0.50- 2.50 Max	1.00 Max	0.040 Max	0.030 Max	18.0-21.0	12.0-14.0	3.0 - 4.0	0.75 Max

Mechanical properties of all-weld metal as per AWS

UTS (N/mm ²)	Elongation (L=4d) %
520 Min	30.0% Min

Welding Positions



Packaging & Welding Current

SIZE (mm)	Kg / Packet	Kg. Per Carton	Current (Amps)	In Amps
2.50 x 350	2	12	AC/ DC (+)	50-80
3.15 x 350	2	12		80-110
4.00 x 350	2	12		110-140
5.00 x 350	2	12		140-180

