K-317LT

Austenitic Stainless welding wire (Low C, 19%Cr-13%Ni-Mo)

Classifications

EN ISO 17633-B:2008	: TS317L-FC1	KS D 3612	: YF-317LC
AWS A5.22-15	: E317LT1-1	JIS Z 3323	: TS317L-FC1

Description

- K-317LT is designed for MAG welding of low carbon 19%Cr-13%Ni-3%Mo stainless steels and the principal area of application is process and chemical plant, shipbuilding as well as nuclear plant industries (AISI 316L, 316LN, 317L, 317LN, UNS S31726)
- Wire is a titania type of flux cored wire for all-position welding and it has self-detaching slag, spray-like arc transfer, excellent weldability and increased creep resistance at elevated temperature.
- It contains higher levels of Mo for increased corrosion-resistance when compared to the K-316LT.
- The weld metal contains optimum ferrite contents in their austenitic structures, Therefore their weldability is excellent with lower crack susceptibility.

Welding positions

Polarity & shielding gas

- CO_2: 100% CO_2 (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Ni	Mo	FN
CO_2	0.03	0.56	1.00	19.60	13.30	3.85	11.0

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -20℃	IV (J) -40℃	Remarks
AWS A5.22		min. 520	min. 20			
EN ISO 17633-B		min. 520	min. 20			
Example	390	650	32	55	44	CO_2

Notes on usage and welding condition

- Refer to page 304 for more information on usage
- When heat input is excessive, the impact value tends to be reduced. Therefore, perform welding with selecting proper heat input

Package

Dia. (mm)	0.9	1.2	1.6
Spool (kg)		5, 12.5, 15	

Approvals

Shielding gas	Others
CO_2	CE, JIS