

# Gas Metal Arc Welding

JIS Z3321 Y317  
AWS A5.9 ER317  
DIN 8556-SG 1.4440

## MS M-317 Solid Wires for Stainless Steel

**Applications** Suitable for welding of 317 stainless steel is utilized in severely corrosive environments where crevice and pitting corrosion are of concern

Brand Name		MS M-317							
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.08	≤ 0.65	1.0-2.5	≤ 0.03	≤ 0.03	13.0-15.0	18.5-20.5	3.0-4.0	-
Mechanical property of deposited metal									
Tensile strength	≥ 550 N/mm <sup>2</sup>								
0.2% Offset strength	≥ 225 N/mm <sup>2</sup>								
Elongation	≥ 30 %								
Impact test	NA								
Welding position	Horizontal/Flat position								
Welding polarity	DC-EP								
Shielding gas	98%Ar - 2%O <sub>2</sub>								
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm				
	80-180A	120-200A	140-250 A	170-300 A	200-350A				
Packing	12.50 kgs standard other packing weight can be provided upon request.								