

Gas Tungsten Arc Welding

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

MS T-317

Filler Rod 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 T-317							
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Representative of length	1000 mm Standard or 950 mm Upon requested								
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	≥ 540 N/mm ²								
0.2% Offset strength	≥ 225 N/mm ²								
Elongation	≥ 30 %								
Impact test	NA								
Welding position	All position								
Welding polarity	DC-EN								
Shielding gas	Ar								
Welding current	Dia. 1.2 mm		Dia. 1.6 mm			Dia. 2.4 mm			
	30-80 A		40-120 A			50-150 A			
Packing									
Inner case weight (kg)	5.00								