

FOR STAINLESS STEEL

AWS E317L-16
JIS D317L-16
KS D317L-16

KST-317L

Typical applications

Welding of low carbon 18%Cr-12%Ni-3%Mo which requires excellent corrosion resistance to sulfuric acid, solutions containing these salts and much hot organic acids such as formic acid.

Coating

Lime titania type.

Characteristics on Usage

- ① Good weldability and performance.
- ② Reduce the susceptibility of pitting.
- ③ Redry the electrode at 300~350°C for 60 minutes prior to use.

Typical chemical composition of all-weld-metal (%)

C	Si	Mn	Cr	Ni	Mo
0.03	0.75	1.24	18.6	12.4	3.3

Typical mechanical properties of all-weld-metal

T · S N/mm ² {kgf/mm ² }	El (%)	5%H ₂ SO ₄
560 {57}	44	4.0g/m ² · hr

Sizes available and recommended currents (AC or DC ⊕)

Dia.	(mm)	2.0	2.6	3.2	4.0	5.0
Length	(mm)	250	300	350	350	350
Amp.	F	40~60	55~80	80~110	110~150	140~180
	V&OH	35~45	40~60	70~90	90~130	-

Welding positions



Approved by