

## Description

A continuous, solid, corrosion-resistant, chromium-nickel-molybdenum wire for welding austenitic stainless alloys of the 19% Cr, 13% Ni, 3% Mo types.

OK Autrod 317L has good resistance to general corrosion and pitting due to its high content of molybdenum. The alloy has a low carbon content which makes it particularly recommended where there is a risk of intergranular corrosion. The alloy is used in severe corrosion conditions, such as in the petrochemical, pulp and paper industries.

## Welding current

DC(+)

## Classifications

SFA/AWS A5.9	ER 317L
EN 12072	G 18 15 3 L

## Typical chemical composition, aw (%)

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	0.5	1.8	19.3	14.0	3.5	<0.3

## Typical mech. properties all weld metal

Yield stress, MPa	390
Tensile strength, MPa	600
Elongation, %	45

## Charpy V

Test temps, °C	Impact values, J
+20	80

## Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V	Deposition rate kg weld metal/hour
0.8	3.4-11.0	50-140	16-22	0.8-2.6
1.0	2.6-7.1	80-190	16-24	0.9-2.6
1.2	4.9-8.5	180-280	20-28	2.7-4.6
1.6	3.2-5.5	230-350	24-28	3.0-5.2