

TG-S317L

PREMIARC™

Filler rod and wire

- Features:
- Suitable for low carbon 18%Cr-12%Ni-2%Mo-N and low carbon 19%Cr-13%Ni-3%Mo steel
- Classification:
- AWS A5.9 ER317L
- Shielding gas:
- Ar
- Identification color:
- 1st Sorrel
- Polarity:
- DCEN

Packaging data

ϕ mm	Spool	Tube		
	kg	kg	Length mm	g/piece
1.6	10	5	1,000	16
2.0	-	5	1,000	25
2.4	-	5	1,000	36
3.2	-	5	1,000	64
Volume mm	240W, 110H, 240L	40W, 35H, 1015L		

Composition (rod and wire mass%)

	Typical	Guaranty ^a
C	0.01	0.03
Si	0.43	0.30~0.65
Mn	1.8	1.0~2.5
P	0.02	0.03
S	<0.01	0.03
Ni	13.1	13.0~15.0
Cr	18.8	18.5~20.5
Mo	3.4	3.0~4.0
Cu	0.04	0.75

Note: ^a Single values are maximum.

Welding parameters (A)

ϕ mm	
1.6	100~200
2.0	100~200
2.4	150~250
3.2	200~300

All-weld mechanical properties

	Typical
0.2%YS (MPa)	410
TS (MPa)	570
EI on 4d (%)	39
IV 0°C (J)	98

Approvals

LR	317L m (Chem)
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