



CEWELD 317L

TYPE	Solid Mag stainless steel welding wire with high Molybdenum content.																		
APPLICATIONS	For welding stabilized and un-stabilized CrNiMo(N) type of steels with high corrosion resistance. Also suitable for dissimilar welds between steel and stainless steel or dissimilar stainless steels. CEWELD 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 when there is a risk of intergranular corrosion. The alloy is used in severe corrosion conditions such as in the petrochemical, pulp, cotton and paper industries.																		
PROPERTIES	Austenitic, non magnetic stainless steel alloy with high mechanical properties and excellent weldability, corrosion resistance is better than AISI 316 due to the high Mo. content. Suitable for use up to 400°C																		
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.9: ER317L</td> </tr> <tr> <td>EN ISO</td> <td>14343-A: G 18 15 3 L</td> </tr> <tr> <td>W.Nr.</td> <td>1.4438</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>	AWS	A 5.9: ER317L	EN ISO	14343-A: G 18 15 3 L	W.Nr.	1.4438	F-nr	6	FM	5								
AWS	A 5.9: ER317L																		
EN ISO	14343-A: G 18 15 3 L																		
W.Nr.	1.4438																		
F-nr	6																		
FM	5																		
SUITABLE FOR	<p>Designed for joining corrosion resistant CrNiMoN steel as well as for austenitic-ferritic joints.</p> <p>ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 26, 27, 28 1.4429, 1.4434, 1.4435, 1.4436, 1.4438, 1.4439, 1.4453, 1.4583, X2CrNiMoN 17 13 5, X2CrNiMoN 17 13 3, X2CrNiMo 18 15 4, X10CrNiMoNb 18 12, X2CrNiMoN17-13-3, X2CrNiMoN18-12-4, X2CrNiMo18-14-3, X3CrNiMnMoN19-16 UNS S31600, S31653, S31703, S31726, S31753 AISI 316Cb, 316L, 316LN, 317L, 317LN, 317LMN</p>																		
APPROVALS	CE																		
WELDING POSITIONS																			
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Cu</th> </tr> </thead> <tbody> <tr> <td>0.01</td> <td>0.45</td> <td>1.4</td> <td>0.02</td> <td>0.01</td> <td>18.8</td> <td>13.6</td> <td>3.5</td> <td>0.12</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Mo	Cu	0.01	0.45	1.4	0.02	0.01	18.8	13.6	3.5	0.12
C	Si	Mn	P	S	Cr	Ni	Mo	Cu											
0.01	0.45	1.4	0.02	0.01	18.8	13.6	3.5	0.12											
MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{P0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>RT</th> <th>-40°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>465</td> <td>550</td> <td>35</td> <td>128</td> <td>70</td> <td>HRC</td> </tr> </tbody> </table>	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	RT	-40°C	As Welded	465	550	35	128	70	HRC		
Heat Treatment	R _{P0,2} (MPa)					R _m (MPa)	A ₅ (%)		Impact Energy (J) ISO-V		Hardness								
		RT	-40°C																
As Welded	465	550	35	128	70	HRC													
REDRYING	Not required																		
GAS ACC. EN ISO 14175	M13, M12																		



CEWELD 317L

317L 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663415257

317L 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720682051221

317L 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663415264

317L 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663415271