

MIDALLOY ER317L BARE WIRE

CLASSIFICATION

- AWS 5.9 Class ER317L/ASME SFA 5.9 Class ER317L
- UNS# S31783 A#8 F#6

DESCRIPTION

- MIDALLOY ER317L stainless steel wire is used for GMAW, GTAW, and SAW welding.

APPLICATIONS

- MIDALLOY ER317L stainless steel wire is used for joining stainless steels with similar composition.
- Because of the elevated molybdenum content, this alloy offers high resistance to pitting and crevice corrosion.
- Low carbon content (.03% max) reduces the possibility of inter-granular corrosion.

TYPICAL CHEMISTRY

C	Mn	Si	Cr	Ni	Mo	S	P	N	Cu
.015	1.60	.40	19.4	14.5	3.50	.005	.015	.05	.20

Ferrite 5-10% per Schaeffler

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	84,500 PSI
YIELD STRENGTH	58,000 PSI
ELONGATION IN 2"	28%

RECOMMENDED WELDING PARAMETERS

PROCESS	DIAMETER	VOLTAGE	AMPERAGE	GAS/FLUX*
TIG (GTAW)	1/16"	14-18	90-130	100% Ar
	3/32"	15-20	120-175	100% Ar
	1/8"	15-20	150-220	100% Ar
MIG (GMAW)	.035" SHORT ARC	16-26	70-160	69%Ar-30%He-1%O ₂
	.035" SPRAY ARC	26-31	150-230	92%Ar-8%Co ₂ or
	.045" SPRAY ARC	28-32	180-280	98%Ar-2%O ₂
SUB ARC (SAW)	3/32"	28-30	275-350	Record IN or
	1/8"	29-32	350-450	Record IND 24

STANDARD PACKAGING

- TIG 10 lb. tube/60 lb. carton
- MIG 30 lb. spool/1200 lb. pallet
- SUB ARC 60 lb. coil/1440 lb. pallet

11/24/09

The contents of this publication are presented for informational purposes only, and while every effort has been made to ensure their accuracy, they are not to be construed as warranties or guarantees, express or implied, regarding the products or services described herein or their use or applicability. We reserve the right to modify or improve the designs or specifications of such products at any time without notice.

Office and Corporate Warehouse
 630 Axminister Drive
 St. Louis, MO 63026 • 636-349-6000 • 800-776-3300
 Fax 636-349-2240

