

## 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"	35%

### 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 <sub>2</sub>
	.035" SPRAY ARC	26-31	150-230	92%Ar-8%Co <sub>2</sub> or
	.045" SPRAY ARC	28-32	180-280	98%Ar-2%O <sub>2</sub>
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

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