

MIDALLOY MASTERCOR™ E317LT1-1/4 AP Flux-Cored Wire

CLASSIFICATION

- AWS 5.22 Class E317LT1-1 and E317LT1-4 and ASME SFA 5.22 Class E317LT1-1 and E317LT1-4
- UNS# W31735 A#8 F#6

DESCRIPTION

- MIDALLOY Mastercor™ E317LT1-1/4 AP is a gas shielded flux-cored wire designed for “all position” welding and can be used with 75% Argon / 25% CO₂.

APPLICATIONS

- MIDALLOY Mastercor™ E317LT1-1/4 AP is used for joining stainless steels with similar composition.
- MIDALLOY Mastercor™ E317LT1-1/4 AP is often used to overlay carbon and low-alloy steels to achieve a Cr-Ni-Moly composition which offers high resistance to pitting and crevice corrosion.
- Low carbon (.04% max) reduces the possibility of intergranular corrosion.

TYPICAL CHEMISTRY

C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
.03	18.7	13.3	3.48	.81	.77	.020	.010	.05	.10

Controlled Ferrite: 5-10% per Schaeffler

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	90,000 PSI
YIELD STRENGTH	69,000 PSI
ELONGATION IN 2"	34%

*Note: Mechanical properties shown using 100% CO₂ shielding gas

WELDING PARAMETERS (with CO₂ shielding gas)

DIAMETER	VOLTAGE	AMPERAGE (WIRE FEED SPEED ipm)	
		FLAT	VERTICAL & OVERHEAD
.045"	24-28	130-200 (250 TO 425)	120-160 (225 TO 300)
1/16"	25-30	180-250 (150 TO 250)	180-220 (150 TO 200)

Note: If using mixed gas, voltage can be increased by 2 volts.

STANDARD PACKAGING

- .045" 33 Lb. Spool
- 1/16" 33 Lb. Spool

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