DW-317L PREMIARC™

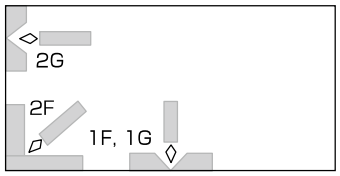
Flux cored wire

Features: ▪ Suitable for 18%Cr-12%Ni-2%Mo-N and 19%Cr-13%Ni-3%Mo steel

Classification: AWS A5.22 E317LT0-1/4

Shielding gas: CO_2 or Ar-CO_2
Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool
1.2	12.5kg
Volume mm	295W, 110H, 295L

Composition (all-weld metal mass%)

	Typical (CO_2)	Guaranty [a]
C	0.03	0.04
Si	0.4	1.0
Mn	1.0	0.5~2.5
P	0.02	0.04
S	<0.01	0.03
Ni	12.8	12.0~14.0
Cr	18.9	18.0~21.0
Mo	3.1	3.0~4.0
Cu	0.04	0.75
Bi	>0.002	-

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G
1.2	130~270	150~220

All-weld mechanical properties

	Typical (CO_2)	Guaranty
0.2%YS (MPa)	380	-
TS (MPa)	590	518min.
El on 4d (%)	37	20min.
IV 0℃ (J)	43	-

Approvals

LR	MG
DNV	VL317L
BV	UP
NK	KW317LG (C)
CWB	E317LT0-1, E317LT0-4

Note: CO_2, except in CWB