DW-317LP PREMIARC™

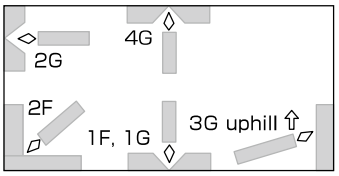
Flux cored wire

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

Classification: AWS A5.22 E317LT1-1/4

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	0.6	1.0
Mn	1.3	0.5~2.5
P	0.02	0.04
S	<0.01	0.03
Ni	13.8	12.0~14.0
Cr	18.6	18.0~21.0
Mo	3.3	3.0~4.0
Cu	0.09	0.75
Bi	>0.002	-

Note: [a] Single values are maximum.

All-weld mechanical properties

	Typical (CO_2)	Guaranty
0.2%YS (MPa)	435	-
TS (MPa)	582	518min.
El on 4d (%)	37	20min.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G	3G uphill	4G
1.2	130~270	150~220	130~220	150~200