NC-317L PREMIARC™

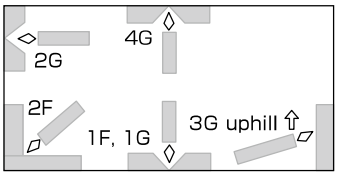
Stick electrode

Features: ▪ Suitable for low carbon 19%Cr-13%Ni-3%Mo steel

Classification: AWS A5.4 E317L-16

Redrying Conditions: 150~200℃x 0.5~1h
Identification color: 1st Sorrel, 2nd Orange
Polarity: AC, DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	19	300W, 100H, 330L
3.2	350	5	20	34	175W, 110H, 380L
4.0	350	5	20	51	175W, 115H, 380L
5.0	350	5	20	79	175W, 115H, 380L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.03	0.04
Si	0.55	1.00
Mn	1.2	0.5~2.5
P	0.03	0.04
S	<0.01	0.03
Ni	13.3	12.0~14.0
Cr	19.7	18.0~21.0
Mo	3.7	3.0~4.0
Cu	0.05	0.75

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	50~85	45~80
3.2	70~115	65~110
4.0	95~145	85~135
5.0	135~180	-

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	440	-
TS (MPa)	600	518min.
El on 4d (%)	39	30min.