

RATNA 317L

An Extra low carbon, 19/13/3 Mo stainless steel Electrode.

CLASSIFICATION : AWS/SFA-5.4: E 317L-16

CHARACTERISTICS : An extra low carbon, 19/13/3 Mo stainless steel electrode with controlled ferrite content of 4-10% for resisting stress corrosion at elevated temperature. The weld metal has creep resistance strength and is of radiographic quality. Gives fine bead and easy slag detachability.

APPLICATION :
Suitable for welding stainless steel exceptional corrosion resistance against inorganic acids such as sulphuric, phosphoric, halogen etc.

RE-DRY CONDITION : Re-Dry the electrode at 300°C for 1 hrs before use.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.04	0.50-2.50	1.00	0.030	0.040	18.0-21.0	12.0-14.0	3.0-4.0	0.75

(single value maximum)

ALL WELD MECHANICAL PROPERTIES:

Tensile Strength (N/mm ²)	ELONGATION %
520 min.	30 min.

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC+/AC) Amps	kg./pkt.	kg./Case
2.50/ 2.40	3/32"	50-75	2	10
3.15/ 3.20	1/8"	80-110	2	10
4.00	5/32"	100-140	2	10
5.00	3/16"	150-180	2	10

Tailor made packing on request.