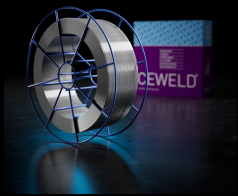


# CEWELD 317L

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                         |                      |                    |                         |       |          |     |      |
|---------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------------------|-------------------------|-------|----------|-----|------|
| TYPE                                              | Solid Mag stainless steel welding wire with high Molybdenum content.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                         |                      |                    |                         |       |          |     |      |
| APPLICATIONS                                      | CEWELD® 317L is suitable for welding stabilized and non-stabilized CrNiMo(N) steels of the 18Cr-14Ni-3Mo type with high corrosion resistance. It is also suitable for mixed welds between steel and stainless steel or dissimilar stainless steels. CEWELD® 317L is used in difficult corrosion conditions, for example in the petrochemical, pulp, cotton, and paper industries.                                                                                                                                                                                                         |                         |                      |                    |                         |       |          |     |      |
| PROPERTIES                                        | <p>CEWELD® 317L has good resistance to general corrosion and pitting due to its high molybdenum content.</p> <p>It is made from a non-magnetic stainless steel alloy that is characterized by high mechanical properties and excellent weldability. Its corrosion resistance is better than that of 316 types due to its increased alloy content. It is suitable for use up to 400 °C.</p> <p>Due to its low carbon content, CEWELD® 317L is particularly recommended when there is a risk of intergranular corrosion.</p> <p>The microstructure is austenitic with 5 to 10% ferrite.</p> |                         |                      |                    |                         |       |          |     |      |
| CLASSIFICATION                                    | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | A 5.9: ER317L           |                      |                    |                         |       |          |     |      |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 14343-A: G 18 15 3 L    |                      |                    |                         |       |          |     |      |
|                                                   | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 1.4438                  |                      |                    |                         |       |          |     |      |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | 6                       |                      |                    |                         |       |          |     |      |
|                                                   | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 5                       |                      |                    |                         |       |          |     |      |
| SUITABLE FOR                                      | <p><b>ISO 15608: 8.1 Austenitic ≤ 19 % Cr</b></p> <p>1.4429, 1.4434, 1.4435, 1.4436, 1.4438, 1.4439, 1.4453, 1.4583, X2CrNiMoN 17 13 5, X2CrNiMoN 17 13 3, X2CrNiMo 18 15 4, X10CrNiMoNb 18 12, X2CrNiMoN17-13-3, X2CrNiMoN18-12-4, X2CrNiMo18-14-3, X3CrNiMnMoN19-16</p> <p>UNS S31600, S31653, S31703, S31726, S31753, J92999</p> <p>AISI 316Cb, 316LN, 317LN, 317L, A351 CG8M, CG3M</p>                                                                                                                                                                                                |                         |                      |                    |                         |       |          |     |      |
| APPROVALS                                         | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                         |                      |                    |                         |       |          |     |      |
| WELDING POSITIONS                                 | <div> PA  PB  PC  PD  PE  PF</div>                                      |                         |                      |                    |                         |       |          |     |      |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Si                      | Mn                   | P                  | S                       | Cr    | Ni       | Mo  | Cu   |
|                                                   | 0.01                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | 0.45                    | 1.4                  | 0.02               | 0.01                    | 18.8  | 13.6     | 3.5 | 0.12 |
| MECHANICAL PROPERTIES                             | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |       | Hardness |     |      |
|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                         |                      |                    | RT                      | -40°C |          |     |      |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 465                     | 550                  | 35                 | 128                     | 70    | HRc      |     |      |
| REDRYING                                          | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                         |                      |                    |                         |       |          |     |      |
| GAS ACC. EN ISO 14175                             | M13, M12                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                         |                      |                    |                         |       |          |     |      |



# CEWELD 317L

317L 0,8MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663415257 |

317L 1,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720682051221 |

317L 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663415264 |

317L 1,6MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663415271 |