

# TASETO Welding Materials

Stainless Steel Electrodes

For Shielded Metal Arc Welding

## RNY 3 1 7 L

### ● Applicable Specification

JIS Z 3221 ES317L-16

AWS A5.4 E317L-16

### ● Identification Color

End Face: Chestnut Color

Side Face: —

### ● Applications and Characteristics

TASETO RNY317L has excellent resistibility to pitting and intergranular corrosion. It is used for welding of 18%Cr-12%Ni-3%Mo stainless steel (Type 317, 317L), which is used for bleaching equipment.

RNY317L is a lime-titania type electrode suitable for positional welding.

### ● Notes on Usage

\* Dry the electrode at 150°C to 200°C for 60 minutes before use.

\* Remove oil and dust from the surface to be welded.

\* Avoid excessively high current to prevent hot cracking.

### ● Chemical Composition of All Weld Metal (%)

|         | C     | Si   | Mn   | P     | S     | Ni    | Cr    | Mo   | Cu   |
|---------|-------|------|------|-------|-------|-------|-------|------|------|
| Typical | 0.034 | 0.63 | 1.62 | 0.011 | 0.009 | 15.91 | 17.82 | 5.13 | 0.13 |

### ● Mechanical Properties of All Weld Metal

|         | Tensile Strength<br>(MPa) | 5D Elongation<br>(%) |
|---------|---------------------------|----------------------|
| Typical | 551                       | 35.4                 |

### ● Sizes Available, Recommended Currents (AC or DCEP)

| Size<br>(mm) | Length<br>(mm) | Welding Current (A) |                    |
|--------------|----------------|---------------------|--------------------|
|              |                | Flat                | Vertical, Overhead |
| 3.2          | 350            | 80~120              | 65~110             |
| 4.0          | 350            | 110~150             | 85~135             |
| 5.0          | 350            | 150~200             | —                  |