

TASETO Welding Materials

Stainless Steel Electrodes

For Flux Cored Arc Welding

GF317L

Applicable Specification

JIS Z 3323 TS317L-FB0
AWS A5.22 E317LT0-1/4

● Applications and Characteristics

TASETO GF317L contains more Mo than GF316L and has excellent resistibility to pitting and intergranular corrosion. GF317L is used for welding of Type 317 and Type 317L stainless steel used in bleaching equipments.

● Notes on Usage

* Please refer "Guideline for Welding Stainless Steel with GF Wires".

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.021	0.60	1.32	0.021	0.005	13.20	19.04	3.48	0.03

● Ferrite Content of All Weld Metal

* Typical Ferrite Content: 8.2% (Schaeffler's Diagram)
13.5FN (DeLong's Diagram)
16% (Ferrite Scope)

● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)	Absorbed Energy (J at 0°C)
Typical	423	589	35.0	59

● Corrosion Resistance of All Weld Metal

* Typical Corrosion Resistance 5.12g/m²·h (5% Sulfuric Acid Test)
180° bend without any defects
(Copper Sulfate-Sulfuric Acid Test : PWHT 650°C × 2h)

● Sizes Available, Shielding Gas

Size (mm)	Shielding Gas
1.2	CO ₂ or Ar+20%CO ₂ , 20L/min
1.6	CO ₂ or Ar+20%CO ₂ , 20L/min