

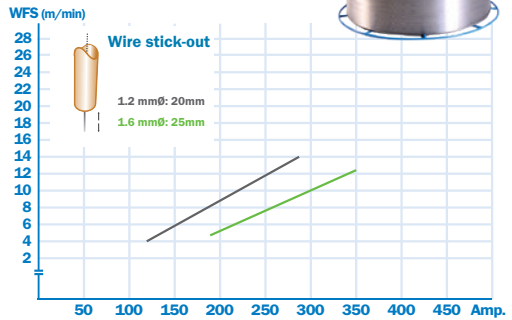
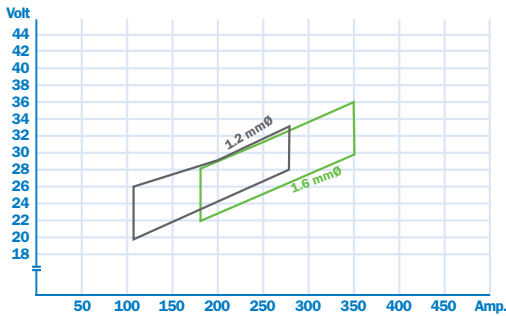
## Description and Application

This is a rutile flux cored wire which operates with a very stable, spatter free arc producing bright, smooth weld bead surfaces and self releasing slag.

**DW-317L** is designed for welding 18%Cr-12%Ni-2.5%Mo-N (type 316LN) or 19%Cr-12%Ni-3.5%Mo (type 317L) stainless steels. Due to the low carbon contents in the weld metal, it is possible to obtain high resistance to intergranular corrosion.



### Recommended Parameter Range, for flat position\*



### Typical Chemical Analysis (wt. %)

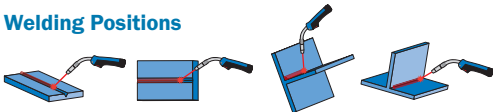
C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.03	0.60	1.10	0.02	0.008	12.6	19.1	3.5	-	-	9.2	11.6	8.7

### Typical Mechanical Properties

	R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	CV(J)+20°C	CV(J)0°C
Guaranty	490	620	35	61	53
	min.350	min.520	min.20		

\* The above values and parameters are for all weld metal produced using Ar+CO<sub>2</sub> shielding gas

### Welding Positions



### Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
-	NV 317 L	-	-	-	CE