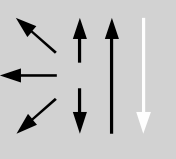


Classification							
EN ISO 3581-A				AWS A5.4			
E Z 19 13 4 N L				E317L-17			
Characteristics and typical fields of application							
Rutile, core wire alloyed electrode with high Mo-content. Suited for corrosion resistant, CrNiMo(N)-steels. It satisfies the high demands of offshore fabricators, shipyards building chemical tankers as well as the chemical / petrochemical, pulp and paper industries.							
Base materials							
CrNiMo-steels with higher Mo-content like grade AISI 317L or corrosion resistant claddings on mild steels 1.4435 X2CrNiMo18-14-3, 1.4429 X2CrNiMoN17-13-3, 1.4438 X2CrNiMoN 18-15-4 AISI 316L, 316LN, 317L, 317LN							
Typical analysis of all-weld metal							
	C	Si	Mn	Cr	Ni	Mo	FN
wt.-%	0.02	0.7	0.9	19.0	13.6	3.6	4-10
Mechanical properties of all-weld metal – typical values (min. values)							
Condition	Yield strength R _{p0,2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J			
	MPa	MPa	%	+20°C			
u	500	610 (≥520)	≥30	≥ 34			
u untreated, as welded							
Operating data							
	Polarity:	Redrying:	Electrode identification:	ø mm	L mm	Amps A	
	DC (+)	250 °C / 3 h	317L-17/SNR	2.5	300	45 – 80	
	AC			3.2	350	70 – 120	
				4.0	350	90 – 160	
			5.0	350	150 – 220		
Preheating and post weld heat treatment is not required by the weld deposit. Interpass temperature max. 100 °C.							
Approvals							
DNV GL							