



FCW 317LP

All positions 317L type
Rutile flux cored wire

Classification

AWS A5.22 : E317LT1-1/-4

ISO 17633-A : T Z 19 13 4 L P M21(C1) 1

Description & Applications

Rutile flux cored wire for gas shielded (Ar + CO₂ or 100% CO₂) arc welding of stainless steel with similar chemical composition. Used where enhanced resistance to pitting and acid corrosion is required. Designed to weld in all positions.

Main applications: Current stainless steel joining

Base materials:

UNS	Grade	EN 10088	N° Mat.
S31600	316	X5 CrNiMo17-12- 2	1.4401
S31603	316L	X2 CrNiMo17-12-2	1.4404
S31635	316Ti	X6 CrNiMoTi17-12-3	1.4571
S31700	317	X3 CrNiMo 18-12-3	1.4449
S31703	317L	X2 CrNiMo 18-15-4	1.4438
S31640	318	X10 CrNiMoNb 18-12	1.4583

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
0.03	0.80	1.4	19.5	13.0	3.5	0.10	0.02	0.01	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
510	620	30	-60°C 40

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	100 - 270	22 - 35	12 - 25	ISO 14175 : M21 (Ar + CO ₂) C1 (100% CO ₂) 12-20 l/min



FT En-CN39-160726

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