



TIG 18/15

Old reference: TIG 317L

Classification

AWS A5.9 : ER317L
 UNS : S31783
 ISO 14343-A : W 18 15 3 L

Description & Applications

Rod for Gas Tungsten Arc Welding low carbon stainless steel composition with about 3,5%Mo. For welding and cladding on austenitic Cr-Ni-Mo stainless and clad plates. Compared to 316L-grades the higher Mo-content provides better general corrosion resistance, especially to crevice and pitting corrosion in chloride containing solutions.

Main applications: Used in the chemical and petrochemical industries, in refineries, in the food industries and for ship building to weld pipes, tanks...

Base materials

Stainless steels for general use:

UNS	Alloy	EN 10088	Material N°	UGINE
S31603	316L	X2CrNiMo17-12-2	1.4404	UGINOX 18-11 ML
S31653	316LN	X2CrNiMoN17-13-3	1.4429	UGINOX 17-10 M
S31700	317	X5CrNiMo17-13-3	1.4449	
S31703	316LMo	X2CrNiMo18-14-3	1.4435	UGINOX 18-13 MS
S31703	317L	X2CrNiMo 18-15-4	1.4438	

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe	FN
0.01	0.4	1.4	18.8	13.6	3.5	0.10	<0.03	<0.02	Rem.	~ 10

All Weld Metal Mechanical Properties

$R_{p0,2}$ (MPa)	R_m (MPa)	A_5 (%)
> 380	> 580	> 30

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding :Argon or Nitrogen /H ₂ : 3 - 6 l/min

Ind.11



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