

FCAW

# DW-317LP

**PREMIARC™**

## Flux cored wire

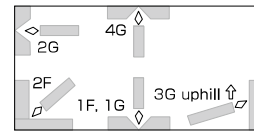
**Features:**     ▪ Suitable for 18%Cr-12%Ni-2%Mo-N and 19%Cr-13%Ni-3%Mo stainless steel

**Classification:** AWS A5.22 E317LT1-1/4

**Shielding gas:** CO<sub>2</sub> or Ar-CO<sub>2</sub>

**Polarity:**       DCEP

### Welding Positions:



## Packaging data

φ mm	Spool
1.2	12.5kg
<b>Volume mm</b>	295W, 110H, 295L

## Composition (all-weld metal mass%)

	Typical (CO <sub>2</sub> )	Guaranty <sup>a</sup>
<b>C</b>	0.03	0.04
<b>Si</b>	0.6	1.0
<b>Mn</b>	1.3	0.5~2.5
<b>P</b>	0.02	0.04
<b>S</b>	<0.01	0.03
<b>Ni</b>	13.8	12.0~14.0
<b>Cr</b>	18.6	18.0~21.0
<b>Mo</b>	3.3	3.0~4.0
<b>Cu</b>	0.09	0.75
<b>Bi</b>	>0.002	-

Note: <sup>a</sup> Single values are maximum.

## All-weld mechanical properties

	Typical (CO <sub>2</sub> )	Guaranty
<b>0.2%YS (MPa)</b>	435	-
<b>TS (MPa)</b>	582	518min.
<b>El on 4d (%)</b>	37	20min.

## Welding parameters (A)

φ mm	1F, 1G, 2F	2G	3G uphill	4G
1.2	130~270	150~220	130~220	150~200