

# ES 317L-17

Type Acid-rutile

SMAW

E317L-17

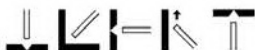
**ESWECO**  
*The Art of Welding*

## Description

ES 317L-17 is an acid-rutile electrode for welding 19Cr 13Ni 3.5Mo (317L) austenitic stainless steels. The high Mo content provides better resistance to acid and pitting corrosion compared with 316L types. ES 317L-17 is easy to weld in all positions and yields smooth runs on both AC and DC.

### Current

DC+, AC OCV 55 V



## Classifications

EN 1600	E 19 13 4 N L R 3 2
SFA/AWS A5.4	E317L-17
WerkstoffNr.	(1.4447)

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.04	0.7	0.9	19.0	13.0	3.8	<0.3

## Typical mech. Properties all weld metal

Yield stress, MPa	480
Tensile strength, MPa	600
Elongation A5, %	30

### Charpy V

Test temps, °C	Impact values, J
+20	45

Ferrite content FN 5-10

## Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	60-90	30
3.2	350	80-125	31
4.0	350	120-170	32