**TIG 317 L**

**Standards**

AWS 5.9  
ER 317L  
EN ISO 14343-A  
W 19 13 4 L  
W. Nr. 1.4438

**Description & applications**

Filler metal in solid wire sticks for TIG welding of austenitic stainless steels with high Molybdenum content type 317L, 316L or similar. The high Molybdenum content insures a very good resistance to localized corrosion such as pitting & crevice corrosion, particularly in the presence of chlorides. Grade 317L is frequently used in the aggressive environments of petrochemical and pulp & paper industries. Also, this grade exhibits a good creep resistance up to 400 °C.

**Typical chemical composition(%)**

<table>
<thead>
<tr>
<th>Cmax</th>
<th>Mn</th>
<th>Si</th>
<th>Cr</th>
<th>Ni</th>
<th>Mo</th>
<th>S max</th>
<th>P max</th>
<th>Fe</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.02</td>
<td>1.7</td>
<td>0.5</td>
<td>19.0</td>
<td>13.5</td>
<td>3.5</td>
<td>0.02</td>
<td>0.02</td>
<td>Base</td>
</tr>
</tbody>
</table>

**Typical mechanical properties of all-weld metal**

<table>
<thead>
<tr>
<th>Rm</th>
<th>Rp 0,2</th>
<th>As</th>
<th>KV-196°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>600 MPa</td>
<td>400 MPa</td>
<td>37 %</td>
<td>50 J</td>
</tr>
</tbody>
</table>

**Operating parameters**

**Shielding gas recommendations:**

EN ISO 14175 I1 : 100 % Argon : 6-12 l/mn  
Root : Argon, Nitrogen : 3-6 l/mn

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