

ARCTEC® FCS 317L

Conforms to: AWS A5.22-95 E317LT1-1/T1-4
ASME SFA5.22



a quality welding alloy

GENERAL CHARACTERISTICS:

ARCTEC® FCS 317L is an all position flux cored wire for joining stainless steels. This filler metal has a nominal composition of 19% chromium 13% nickel and 3% molybdenum. The low carbon content increases resistance to intergranular corrosion without the addition of stabilizers such as columbium or titanium. It produces a smooth weld bead and can be used in all positions observing recommended operating parameters. Shielding gas is required.

APPLICATIONS:

ARCTEC® FCS 317L is used for joining and cladding of alloys of similar composition and are usually limited to severe corrosion application involving sulfuric and sulfurous acids and their salts. Extensively in use in the pulp and paper industry.

MECHANICAL PROPERTIES:

Tensile Strength 91,700psi(632Mpa)	Yield Strength 68,800psi(474Mpa)	Elongation 34%-2"
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OPERATING PARAMETERS:

WELDING PROCESS: FCAW POLARITY: DC Reverse SHIELDING GAS: 75% Argon /25% CO₂ recommended. 100% CO₂ can be used

Optimum Operating Parameters					
Diameter	Position	Stickout	Wire Feed Speed	Amps	Volts
.045"	Flat	1/2-3/4"(12.5-19mm)	450"/min. (191mm/sec)	180-200	25-27
.045"	Horizontal	1/2-3/4"(12.5-19mm)	450"/min. (191mm/sec)	180-200	24-32
.045"	Vertical up	1/2-3/4"(12.5-19mm)	325"/min. (138mm/sec)	150-170	24-26
.045"	Overhead	1/2-3/4"(12.5-19mm)	425"/min. (180mm/sec)	175-195	25-28
1/16"	Flat	5/8-1"(15-25mm)	264"/min. (112mm/sec)	220-240	24-31
1/16"	Horizontal	5/8-1"(15-25mm)	235"/min. (99mm/sec)	200-220	24-29
1/16"	Vertical up	5/8-1"(15-25mm)	220"/min. (93mm/sec)	190-210	24-27
1/16"	Overhead	5/8-1"(15-25mm)	235"/min. (99mm/sec)	170-270	24-29

STANDARD SIZE AND PACKAGING:

Size			Packaging
.035" (.90mm)	.045" (1.2mm)	1/16" (1.5mm)	12" spools (15 Kg)

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Subject to change without notice

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