



ARCTEC® E316L-17 AWS A5.4 Class E316L-17

DESCRIPTION AND APPLICATION:

Arctec® E316L-17 produce a concave weld bead with minimum ripple and has a virtually self lifting slag. The excellent wetting action and very fine ripple minimize crevice corrosion and grinding time. The low carbon content of this filler metal reduces the risk of carbide precipitation and thus increases the resistance to intergranular corrosion. The addition of molybdenum increases the resistance to pitting corrosion caused by corrosive media such as sulfuric acids, chlorides and cellulose solutions. Primarily used for welding low carbon molybdenum bearing austenitic alloys.

Typical Mechanical Properties: Tensile Strength: 77,500 psi (534 MPa) Elongation 45% - 2"
Typical Deposit Analysis:

	C	Cr	Ni	Mn	Si	Mo
%	.02	18.0	12.0	.70	.75	2.80

WELDING PROCESS: SMAW

POLARITY: DC Reverse or AC

Recommended Amperage:

Diameter	1.5 mm 1/16"	2.0 mm 5/64"	2.50 mm 3/32"	3.25 mm 1/8"	4.0 mm 5/32"	5.0 mm 3/16"
Amperage	30-50	40-60	60-80	80-100	110-140	140-180

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DESCRIPTION AND APPLICATION:

Arctec® E317L-17 is primarily used for welding alloys of similar composition and is utilized in severely corrosive environments where crevice and pitting corrosion is of concern. The low carbon content of this filler metal reduces the risk of carbide precipitation and thus increases the resistance to intergranular corrosion. The addition of molybdenum increases the resistance to pitting corrosion caused by corrosive media such as sulfuric acids, chlorides and cellulose solutions.

Typical Mechanical Properties: Tensile Strength: 80,000 to 90,000 psi (552 to 621 MPa) Elongation 35-45% - 2"
Typical Deposit Analysis:

	C	Cr	Ni	Mn	Si	Mo
%	.03	19.0	12.7	1.70	.50	3.50

RECOMMENDED OPERATING PARAMETERS:

The following parameters may be used as a guideline for the stainless steel alloys listed herein.

WELDING PROCESS: SMAW

POLARITY: DC Reverse or AC

Recommended Amperage:

Diameter	1.5 mm 1/16"	2.0 mm 5/64"	2.50 mm 3/32"	3.25 mm 1/8"	4.0 mm 5/32"	5.0 mm 3/16"
Amperage	30-50	40-60	60-80	80-100	110-140	140-180

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