

COVERED ELECTRODES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SS-317L is a titanium oxide low hydrogen electrode, the weld metal contains 19%Cr-12%Ni-3%Mo the austenitic structure.
- To organic acid, sulfuric acid (H₂SO₄), and sulphurous acid (H₂SO₃) advantage of anti-corrosion, stable arc, well weldbead, and slag removal.
- It is suitable for Chemical Container as AISI 316/316L, 317/317L, and SUS 317L steels.

NOTE ON USAGE :

- Re bake the electrodes at 250 ~ 300°C for 1 hour and keep it at 100~150°C prior to use.
- With lower current is to properly keep the dilution of the parent metal for welding crack.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni	Cr	Mo
0.02	0.90	0.60	0.030	0.003	12.90	19.00	3.52

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %
597(60.9)	39

SIZE AND RECOMMENDED CURRENT RANGE : AC or DC(+)

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		300	350	350	350
Current (Amp)	F	50-85	80-120	100-150	140-180
	V & OH	45-80	70-110	90-135	-