

# Stainless Steel SMAW Electrodes

## G317

AWS A5.4 E317-16  
JIS Z 3221 ES317-16

### Product Features:

- Lime titanium oxide type covered electrode for stainless steel, deposited weld metal contains approximately 18%Cr-12%Ni-3.5%Mo elements.
- Weld metal contains higher Mo to get better pitting, crevice corrosion and heat resistance than 316.

### Applications:

- Suitable for welding of SUS 317.

Typical chemical composition of all weld metal (wt%)

| C    | Si   | Mn   | Ni    | Cr    | Mo   |
|------|------|------|-------|-------|------|
| 0.03 | 0.83 | 0.69 | 12.69 | 19.05 | 3.81 |

Typical mechanical properties of all weld metal

| Tensile Strength<br>N/mm <sup>2</sup> | Elongation<br>% |
|---------------------------------------|-----------------|
| 602                                   | 51.7            |

Size (mm) & recommended welding parameters (A) AC or DC+

| Diameter / Length            | 2.0/250 | 2.6/300 | 3.2/350 | 4.0/350 | 5.0/350 |
|------------------------------|---------|---------|---------|---------|---------|
| Flat position                | 30~50   | 60~85   | 85~120  | 115~150 | 150~200 |
| Vertical / overhead position | 30~50   | 50~75   | 75~105  | 95~130  | ----    |

### Note:

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