

Stainless Steel Flux Cored Wire

GMX317L

AWS A5.22 E317LT1-1/4
A5.22M E317LT1-1/4
JIS Z 3323 TS317L-FB1

Product Features:

- GMX317L is especially developed for out-of-position welding. The smooth weld metal transfer and easy slag removal eliminates unnecessary clean up. The weld bead is uniform, flat to slightly concave and free from porosity. Penetration is complete and easy to obtain the flat equal weld leg.
- For welding types of 301,302,304,304L,305,316L steel. The higher molybdenum content will reduce the susceptibility of pitting corrosion and provide excellent resistance to corrosion by organic acid such as sulfuric acid.

Guideline in Usage:

- Use general CO₂ welding machine, but loosen the wire-feeding roller.
- This wire is formulated for using 80% Argon plus 20% CO₂ gas shielded or straight CO₂ gas. However, the 80%Ar / 20%CO₂ mixture gas will produce a smoother arc with less spatter and slight higher yield and tensile strength.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Ni	Cr	Mo	Fe
0.03	0.62	1.72	13.16	19.62	3.47	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %
479	614	30

Size (mm) & recommended welding parameters

Diameter		1.2mm	1.6mm
Polarity		DC+	DC+
Ampere (A)	Flat / Horizontal position	160~220	220~300
	Vertical / overhead position	90~130	-
Shielding Gas		CO ₂ /80%Ar+20%CO ₂	CO ₂ /80%Ar+20%CO ₂

Note:

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