

## MMA Electrodes Stainless and Heat resistant steels

SUPRANOX 317 is a semi-basic MMA electrode suitable for the welding of austenitic stainless steels with 16-20%Cr, 10-14%Ni and 3-4%Mo (AISI 317). The use of these steels is limited to corrosion conditions in the presence of sulphuric and sulphurous acids and their salts. Excellent weldability with a spatter free arc and self-releasing slag to produce a very smooth bead appearance. Efficiency 100%.

### Classification

EN	1600: E 19 13 4 N L R 12 (nearest)
AWS	A5.4: E 317L-16

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Ferrite
0.025	0.9	0.8	≤ 0.03	≤ 0.03	20	13	3.4	5-10

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				20 °C
As Welded	≥ 350	≥ 550	≥ 30	≥ 27

### Materials

1.4434 (X2CrNiMoN18-12-4); 1.4438 (X2CrNiMo18-15-4); 1.4429 (X2CrNiMoN17-13-3)

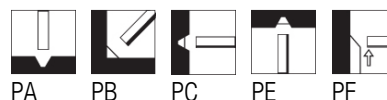
AISI 317L - 317LN

### Storage

Keep dry and avoid condensation.  
Re-drying not generally required  
If necessary: 350-370 °C for 1 hour, 3 times max

### Current condition and welding position

AC; DC+



### Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	VPMD	
				PC	Code
2.5	300	50-80	18.7	90	●
3.2	350	60-120	35.8	55	●
4.0	350	100-140	55.05	40	●