

Flux Cored Wire for Stainless Steel

KFW-317F

Classification

Shielding gas:

CO₂ or Ar+20%CO₂

AWS	E317T0-1/4	—
JIS	Z3323	TS317L-FB0
EN	17633-A	T Z19 13 4 L R M 3
GB	—	—

Applications and Features

- (1) Weld metal is 19%Cr-13%Ni-3%Mo.
- (2) It provides good corrosion, pitting and heat resistance to sulfuric and sulphurous acid due to high Mo content.
- (3) It is ideal for welding critical chemical vessels.

Welding Instruction

- (1) Please refer to Appendix H for re-drying instructions.
- (2) For other instructions, please refer to Appendix D.
- (3) For extra information, please refer to Appendix F.

Typical Chemical Composition of Weld Metal (wt %) (Shielding Gas : Ar+2%O₂)

C	Si	Mn	P	S	Cr	Ni	Mo
0.025	0.59	1.10	0.02	0.01	19.52	13.02	3.36

Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar+2%O₂)

Tensile Strength N/mm ² (kgf/mm ²)	Yield Strength N/mm ² (kgf/mm ²)	Elongation %
560	390	35

Size and Suggested Operating Range (DC+)

Operating range	Diameter (mm)	0.8	0.9	1.0	1.2	1.4	1.6	
		Ar+1~2%CO ₂	Amp	—	60~140	80~160	100~210	—
		Volt	—	15~21	16~22	17~22	—	—
Ar+1~2%O ₂	Amp	—	170~260	180~280	200~300	210~320	220~330	
	Volt	—	24~30	24~30	24~30	24~32	24~32	