

## FLUX CORED STAINLESS STEEL ELECTRODES DM317LT-1

**Classification:** E317LTX-X

**AWS A5.22 ASME SFA 5.22**

### Description, Characteristics & Applications:

It is recommended for welding type 317 stainless with a maximum of .04% carbon in the weld deposit. The higher molybdenum content, as compared to the type 316L, further reduces susceptibility to pitting corrosion. It is used in the pulp and paper industry and in other severe corrosion applications involving sulfuric and sulfurous acids and their salts.

For best results, set the wire feed speed and adjust the voltage for smoothest operation. Electrode extension range is from 1/2" to 1," with an optimum range of 5/8" to 3/4." Weld using reverse polarity DC(+).

#### Shielding Gas

75% argon / 25% CO<sub>2</sub> (or nearest equivalent) shielding gas; however, straight CO<sub>2</sub> may also be used. The 75/25 mixture will produce a smoother arc with virtually no spatter and slightly higher yield and tensile strengths than CO<sub>2</sub>. The mechanical properties and deposit analyses will meet AWS A5.22 specifications with either gas.

### Typical Chemical Composition (%)

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
0.04 max	18.0-21.0	12.0-14.0	3.0-4.0	0.5-2.5	1.00 max	0.04 max	0.03 max	0.75 max

### Deposited Chemical Composition (%) (Typical)

C	Cr	Ni	Mo	Mn	Si	P	S
0.03	20.0	13.0	2.75	1.75	0.65	0.03	0.02

### Typical Mechanical Properties as Welded

Tensile Strength	Yield Strength	Elongation (%)	Hardness	Ferrite WRC (FN)	CVN Impacts (J)	
					@	°C
80,000psi	-----	24%	-----	-----	-----	

Diameter	Position	WFS	Opt Amps	Opt Volts	Range Amps	Range Volts
.035	Flat	365 / min	130-140	24-25	100-170	21-26
	Horizontal	365 / min	130-140	24-25	100-170	21-26
	Vertical-Up	310 / min	110-120	22-23	110-120	21-23
	Overhead	320 / min	120-130	23-24	120-130	22-24
.045	Flat	450 / min	180-200	25-27	135-250	24-32
	Horizontal	450 / min	180-200	25-27	135-250	24-32
	Vertical-Up	325 / min	150-170	24-26	135-200	24-26
	Overhead	425 / min	175-195	25-27	155-200	25-28
1/16	Flat	264 / min	220-240	25-27	170-300	24-31
	Horizontal	235 / min	200-220	25-27	170-270	24-29
	Vertical-Up	220 / min	190-210	25-26	170-230	24-27
	Overhead	235 / min	200-220	25-26	170-270	24-29

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