

AK E317-16

Description: A rutile stainless steel electrode designed to weld Cr19Ni13Mo3 steel. With excellent operation and processing properties. The high Mo content provides better resistance to acid and pitting corrosion compared with 316L types.

Application: Used to weld similar stainless steels, clad steels and dissimilar steels.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	Cu
Requirement	0.08	1.00	0.5-2.5	0.03	0.03	12.0-14.0	3.0-4.0	18.0-21.0	0.75
Actual Result	0.06	0.68	0.82	0.005	0.018	13.42	3.43	19.65	0.25

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 550		≥20	
Actual Result	600		40	

Recommended welding parameters:

Diameter/mm		2.5	3.2	4
Welding current/A	F/H	60-80	80-120	100-150
	V/ OH	40-70	60-100	80-130