317LT1-1
Flux Cored Wire

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com

Quality Management System
in accordance with
ISO 9001
Cert # 05-R0925

American Welding Society
Sustaining Company Member

GAWDA
GASES AND WELDING DISTRIBUTORS ASSOCIATION

ALLOY DESCRIPTION AND APPLICATION;

E317LT1-1 is a flux-cored wire for single or multi-pass welds on stainless steels. E317LT1-1 is noted for its low spatter generation, excellent bead shape and appearance and ease of slag removal. It has very good deposit efficiency when used for flat and fillet welds of medium and heavy thickness plates. It has been designed to be used with 100% CO2 shield gas. E317LT-1 provides weld deposits with optimum ferrite content as its austenitic structure resulting in low susceptibility to cracking. The extra low carbon content of E317LT-1 provides excellent resistance to inter- granular corrosion and stress corrosion cracking caused by carbide precipitation. E317LT-1 also provides excellent resistance to pitting corrosion due to its higher Molybdenum content compared to 316LT-1. Used extensively in the fabrication of AISI type 317 stainless steel structures, pressure vessels, and tanks in dairy, pulp and paper, textile dyeing, refinery and chemical equipment. The extra low carbon content reduces carbide precipitation. E317LT-1 can be used to weld stainless steels of similar compositions when welds are required to meet higher resistance requirements. One key advantage of E317LT-1 is its excellent resistance to pitting corrosion in chlorine environments. It is also used for pollution control equipment where the corrosive attack is too severe for E316LT-1 filler metal. E317LT0-1/-4 may be more fluid giving a flat to concave bead profile.

TYPICAL WELDING PROCEDURES; DCEP

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stickout	CO_2 (cfh)
0.045”	215-550	140-380	23-35	1/2-1”	35-50
1/16”	125-615	150-410	24-36	5/8-1.25 ”	35-50

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

CHEMISTRY (%) for Undiluted WELD METAL & PROPERTIES

	AWS Requirements)	Typical		(AWS Requirements)	Typical
Carbon	0.04	0.03	Molybdenum	3.00-4.00	3.59
Manganese	0.5-2.5	1.78	Phosphorus	0.04	0.024
Silicon	1.00	0.65	Sulfur	0.03	0.018
Chromium	18.0-21.0	18.95	Nickel	12.0-14.0	13.30

	AWS Requirements	As Welded
Tensile Strength (psi)	75,000 min.	88,600
Yield Strength (psi)	N/A	76,750
Elongation	15% min.	34%

Iron balance and all single values are maximum percentages unless noted

AVAILABLE SIZES: TSF 317LT

Other sizes available – please inquire

SPECIFICATIONS; **ANSI/AWS** A5.22 E317LT0-1/-4 or E317LT1-1/-4
ASME SFA 5.22 E317LT0-1/-4 or E317LT1-1/-4
ASME F-6 , A-8

T0 = flat and horizontal: T1 = all position: -1 is for 100% CO2; -4 = 75-80 Ar /CO2

EAST COAST
7010-G Reames Rd
Charlotte, NC 28216
Tel (888) 522-8296
Fax (704)598-6673

GULF COAST
4755 Alpine Drive #100A
Stafford, TX 77477
Tel (877) 711-9274
Fax (281)313-6332

WEST COAST
8535 Utica Ave
Rancho Cucamonga, CA 91730
Tel (800)830-9033
Fax (909)291-4586

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Warehouse Distribution Center – Portland, Oregon Head Office – Puyallup,