



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

317L-16 Coated Electrode

U.S. ALLOY CO.
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American Welding Society
Sustaining Company Member



ALLOY DESCRIPTION AND APPLICATION;

317 electrodes have a greater molybdenum content than USA 316. The increased molybdenum content results in a weld deposit with higher tensile strength at elevated temperatures, stronger resistance against pitting corrosion, and virtually immune from cracking as the deposit cools down from the molten stage. USA 317 weld deposits exhibit smooth bead appearance and easy slag removability. This electrode is typically used where strong corrosion resistance against sulfuric or sulfurous acids is required such as in the chemical, paper and textile industries.

TYPICAL WELDING PROCEDURES; DCEP

Diameter	Amps	Diameter	Amps
1/16"	20-40	1/8"	80-110
5/64"	35-50	5/32"	105-145
3/32"	55-75	3/16"	165-200

Arc Length = short arc, Flat use 15° angle from 90°, Vertical up & Overhead use weaving techniques within puddle

Procedures may vary with change in position, base metals, filler metals, equipment, and other changes.
When welding vertical reduce amperage 10-20%

TYPICAL CHEMISTRY (%) & WELD METAL PROPERTIES

Carbon	0.050	Molybdenum	2.16
Manganese	1.93	Phosphorus	0.020
Silicon	0.39	Sulfur	0.012
Chromium	19.68	Nickel	12.15
	Elongation		39%
	Yield Strength (psi)		57,000
	Tensile Strength (psi)		87,000

Iron balance and all single values are maximum percentages

AVAILABLE SIZES: TF317L-16 = 3/32", 1/8", 5/32", 5/32"

SPECIFICATIONS; ANSI/AWS A5.4 E317L-16
ASME SFA 5.4 E317L-16

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