

SUPRANOX RS 317

MMA Electrodes Stainless and Heat resistant steels

Semi-basic MMA electrode suitable for the welding of austenitic stainless steels with 16-20% Cr, 10-14% Ni and 3-4% Mo (AISI 317). The use of these steels is limited to corrosion conditions in the presence of sulphuric and sulphurous acids and their salts. Excellent weldability with a spatter free arc; self-releasing slag combined with a very smooth bead appearance. Efficiency 100%. Packed in Gaspack system.

Classification	
AWS	A5.4: E 317-16
EN	1600: E 19 13 4 NL B 12

Approvals	Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.04	0.90	0.80	≤ 0.030	≤ 0.030	19	13	3.50	-	-	-	5-10

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) 20°C	Hardness
As Welded	≥ 350	≥ 550	≥ 30	≥ 27	-

Materials

1.4434 (X2CrNiMoN18-12-4); 1.4438 (X2CrNiMo18-15-4); 1.4429 (X2CrNiMoN17-13-3)

AISI 317L - 317LN

Storage and redrying

Keep dry and avoid condensation.

Re-drying not generally required

If necessary: 350-370 °C for 1 hour, 3 times max

Current condition and welding position

AC; DC+



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	50-80	18,7	11,2
3,2	350	70-120	35,8	21,4
4,0	350	110-140	55,1	33,0