Pinnacle Alloys are products of SOWESCO

ISO 9001:2008 REGISTERED
Certificate No.: 50040 & 50415

E317-16/E317L-16 DATA SHEET

Pinnacle Alloys E317-16/E317L-16
AWS CLASS E317-16, E317L-16
CODE AND SPECIFICATION DATA:
AWS A5.4 ASME SFA 5.4; UNS W31710 (317) & UNS W31713 (317L)

DESCRIPTION:
Pinnacle Alloys E317-16/E317L-16 has a nominal composition (wt.-%) of 19.5 Cr, 12.75 Ni, 3.5 Mo, and a maximum carbon content of 0.04. This carbon restriction reduces the possibility of intergranular carbide precipitation and thereby increases the resistance to intergranular corrosion without the use of stabilizers such as niobium or titanium. The low-carbon alloy however, is not as strong at elevated temperatures as the niobium-stabilized alloys or the standard type 317 weld metal with higher carbon content. Pinnacle Alloys E317-16/E317L-16 is usually used for welding alloys of similar composition and are utilized in severely corrosive environments (such as those containing halogens) where crevice and pitting corrosion are of concern, such as food processing plants, paper industries, chemical processing facilities, and marine applications.

TYPE OF CURRENT: Direct Current Electrode Positive (DCEP) or AC

DIAMETERS: 3/32”, 1/8”, 5/32”, 3/16”

WELDING POSITIONS: All positions
3/16” is recommended for use in flat and horizontal positions only

TYPICAL DEPOSIT COMPOSITION:

	AWS Spec	Weld Metal Analysis (%)
Carbon (C)	0.04	0.03
Chromium (Cr)	18.0-21.0	19.0
Copper (Cu)	0.75	0.06
Manganese (Mn)	0.5-2.5	1.20
Molybdenum (Mo)	3.0-4.0	3.80
Nickel (Ni)	12.0-14.0	13.0
Phosphorus (P)	0.04	0.02
Silicon (Si)	1.00	0.36
Sulfur (S)	0.03	0.002

NOTE: Single values are maximums.

SOWESCO, LLC www.pinnaclealloys.com
9384 Wallisville Road • Houston, Texas 77013 • **1-800-856-9353** • (713) 688-9353 • Fax (713) 688-6985
2602 S. 50th Avenue • Phoenix, Arizona 85043 • **1-866-442-9353** • (602) 442-9353 • Fax (602) 442-9354

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FERRITE NUMBER AND PITTING RESISTANCE EQUIVALENT NUMBER:

To obtain Ferrite Numbers or PRE_N, please contact SOWESCO technical support at the number below.

TYPICAL MECHANICAL PROPERTIES:

	AWS Spec (min)	As Welded
Ultimate Tensile Strength	80,000 psi (550 MPa)	90,000 psi (620 MPa)
Percent Elongation in 2”	30%	38%

TYPICAL WELDING PARAMETERS:

Diameter	Type of Current	Amperage Range		Voltage Range
		Flat	Out of Position	
3/32”	DCEP or AC	70-90	65-80	20-23
1/8”	DCEP or AC	80-110	75-95	21-24
5/32”	DCEP or AC	120-160	100-120	22-25
3/16”	DCEP or AC	170-190	Not recommended	23-26

NOTE: Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.

NOTICE: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for the use in the field. The manufacturer disclaims any warranty of merchantability of fitness for any particular purpose with respect to its products.

CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, “Safety in Welding and Cutting,” published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CRF 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.

Pinnacle Alloys SDS sheets may be obtained on the website below.