Solid Wire Electrode for MIG/MAG Welding

BA-MIG 317L

Classification: EN ISO 14343-A: **G 19 13 4 L**
SFA-5.9: **ER317L**

Main Application:
BA-MIG 317L is a solid wire electrode for GMAW, suitable to weld 19Cr/13Ni/3.5Mo austenitic stainless steels type 317L. The increase Mo content compared to grade 316L assures increased resistance to pitting and crevice corrosion. Also suitable for the welding of 316, 316L and 316LN grades, when is necessary to provide better pitting corrosion resistance. Suitable for service temperatures from -60 °C to +300 °C.

Typical analysis and chemical composition acc. to EN ISO 14343-A and AWS A5.9: (Weight Percent)

Wire electrode	C	Si	Mn	Mo	Ni	Cr	P	S	Cu total
Typical analysis BA-MIG 317L	0.015	0.4	2.1	3.6	13.7	19.0	0.020	0.013	0.1
G 19 13 4 L acc. to ISO 14343-A	0.03	1.0	1.0-5.0	3.0-4.5	12.0-15.0	17.0-20.0	0.03	0.02	0.3
ER317L acc. to AWS A5.9	0.03	0.30-0.65	1.0-2.5	3.0-4.0	13.0-15.0	18.5-20.5	0.03	0.03	0.75

All - Weld Metal Mechanical Properties / Welding Data:

Heat Treatment	As Welded
Yield Strength Re, N/mm² (ksi)	350 (51)
Tensile Strength Rm, N/mm² (ksi)	550 - 650 (80-94)
Elongation A5 [%]	>30
Impact Energy ISO-V, J (ft lbs)	+20°C: 100 (74)
Current/polarity	DC +
Shielding Gas	ISO 14175: M12/M13

Base Materials:
1.4435/ X2CrNiMo18-14-3, 1.4429/ X2CrNiMoN17-13-3, 1.4438/ X 2 CrNiMo 18-15-4, AISI 316L, 316 LN, 317LN, 317L.

Package Forms:
Spools BS300/15 kg, D200/5 kg, and drums as standard package forms for GMAW wire electrodes.

Diameter:
0,8 – 1,6 mm. Sizes and tolerances acc. to ISO 544 and AWS A5.9.

Wire Electrode Surface:
Smooth finish free from surface defects and foreign matter.