

# Solid Wire Electrode for Submerged Arc Welding

# BA-WIRE 317L

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

**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-WIRE 317L	0.015	0.5	1.9	3.6	13.7	19.0	0.015	0.013	0.1
S 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	0.5
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

## Application:

BA-WIRE 317L is a submerged arc welding wire intended for welding 19Cr/13Ni/3.5Mo austenitic stainless steels type 317L. The increased Mo content compared to grade 316L assures increased resistance to pitting and crevice corrosion. Also suitable for the welding of 316 or 316L or grade 316LN when it is necessary to provide better pitting corrosion resistance. Suitable for service temperatures from –60 °C to +300 °C.

## 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.  
Suitable fluxes: BF 38, WP 380

Flux type suitability is strongly dependent on its application. In combination with the wire electrode the most suitable flux should match the requirements of the plate material as closely as possible under the existing welding conditions. Further information can be obtained from the technical flux data sheets.

## Package forms:

Coils, spools, drums and spiders as standard package forms for SAW-wire electrodes, different package forms on request.

## Diameter:

1.6 – 4.0 mm; sizes and tolerances acc. to ISO 544 and AWS A5.9.

## Wire electrode surface:

Smooth finish free from surface defects and foreign matter.