



UNIBRAZE 317L-16

CLASSIFICATION: AWS A5.4 / ASME SFA 5.4 E317L-16 UNS W31713

DESCRIPTION: Unibraze 317L-16 is an all position 19%Cr-12%Ni- 3%Mo electrode for welding AISI 317L stainless steel. It provides good corrosion and heat resistance due to the low C (.04% max.) and increased Mo content. It has good strength at high temperatures and post weld heat treatment is not required. Unibraze 317L-16 is ideal for welding critical chemical vessels for sulfuric and sulfurous acid.

TYPICAL CHEMISTRY

C	Si	Cr	Ni	Mn	P	Cu	S	Mo
.034	.36	19.61	13.85	1.49	.015	.10	.010	3.52

TYPICAL MECHANICAL PROPERTIES

Tensile Strength	84,120 psi
Yield Strength	62,370 psi
Elongation	41%
5% Sulfuric Acid Corrosion Test (g/m ² hr)	≤5

SUGGESTED OPERATING RANGE (AC or DC+)

	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)	3/16" (4.8mm)
F/H-Fillet	50-85 amps	80-120 amps	100-150 amps	140—200 amps
V-up/OH	45-85 amps	70-110 amps	90-135 amps	