# CSF-317L(P)

For 18%Cr-12%Ni-3%Mo Stainless steel

| | | |
|---|---|---|
| AWS | A5.22 | E317LT0(1)-1/-4 |
| KS | D 3612 | YF317LC |
| JIS | Z3323 | TS317L-FB0(1) |

## Applications

CSF-317L(P) is suitable for welding of low carbon 18%Cr-12%Ni-3%Mo stainless steel.

## Characteristics

(1) CSF-317L(P) is flux cored wire and designed for Fillet & H-F(All-position) welding with $CO_2$ gas Shielding.
(2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.
(3) Is containing Ferrite of a reasonable quantity and crack-resistance, integranular corrosion resistance, mechanical properties of weld metal is superior.
(4) Shield gas is 100%$CO_2$ or Ar+$CO_2$ gas.

## Notes on usage

(1) The optimum flow of $CO_2$ for Shielding is 20~25ℓ/min.
(2) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
(3) Keep the distance between tip & base metal at 15~25mm.

## Typical chemical composition of weld metal (%)

(Shielding Gas : 100%$CO_2$)

| | C | Mn | Si | P | S | Cr | Ni | No | FN |
|---|---|---|---|---|---|---|---|---|---|
| CSF-317L | 0.03 | 1.35 | 0.55 | 0.018 | 0.015 | 19.6 | 12.4 | 3.3 | 9 |
| CSF-317LP | 0.03 | 1.10 | 0.58 | 0.020 | 0.008 | 19.2 | 12.6 | 3.1 | 10 |

## Typical mechanical properties of weld metal

(Shielding Gas : 100%$CO_2$)

| | YP N/mm²(MPa) | TS N/mm²(MPa) | EL % | IV (J) 0℃ |
|---|---|---|---|---|
| CSF-317L | 480 | 615 | 35.0 | 42 |
| CSF-317LP | 490 | 620 | 36.0 | 50 |

## Size & recommended current range (DC+)

| Dia. mm (in) | Current(A) | Voltage(V) | Welding Speed(cm/min) |
|---|---|---|---|
| 1.2(0.045) | 150~300 | 24~33 | 20~60 |
| 1.6(0.062) | 200~400 | 24~33 | 20~60 |