



**UNIWELD IND. DE ELETRODOS LTDA**

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COMERCIAL DESIGNATION: **ESSEN CN 317 L IG**

PATTERN: AWS ER 317 L

|                         |   |    |    |    |    |
|-------------------------|---|----|----|----|----|
| ALLOY ELEMENTS INCLUDED | C | Si | Mn | Cr | Ni |
|-------------------------|---|----|----|----|----|

|                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                       |                                      |                                    |         |
|-----------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------|--------------------------------------|------------------------------------|---------|
| APPLICATION FIELD           | Special wire and small rods of stainless steel for welding steel with similar and dissimilar high resistance, with medium and high carbon tenor and low alloy steel and tools steel. Its deposit should not be submitted to temperatures up to 300°C.                                                                                                                                                                                                                                                                                                                                  |                                       |                                      |                                    |         |
| MECHANICAL PROPRIETIES      | Traction resistance: mín. 520 RT (MPa)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                       |                                      |                                    |         |
| OPERATIONAL CHARACTERISTICS | For process TIG or MIG Small rods and Bobbins                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                       |                                      |                                    |         |
|                             | Welding Position:: -----                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                       |                                      |                                    |         |
|                             | ∅ Inmm                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 0,80 MIG<br>1,60 Small rods           | 1,00 MIG<br>2,40 Small rods          | 1,20MIG<br>3,20 Small rods         | 1,60MIG |
| Package                     | Bobbins 15-18 kg<br>Small rods 10kg                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Bobbins: 15-18 kg<br>Small rods 10 kg | Bobbins: 15-18 kg<br>Small rods 10kg | Bobbins 15-18kg<br>Small rods 10kg |         |
| WELDING TECHNIQUES          | Remove the ink, grease, rudiness of the area to be welded, prepare the junction following the rules. Regulate the necessary flowing out gas, avoid oscilant movements (zig-zag) during the welding process so it will not fail to protect the arch when it touches the corners. Keep the torch in a correct distance in accordance to the chamfer. Regulate the fount according to the thickness of the part and the small rod. To stablish the arch use the copper plate, use CHEM-SHARP automatically to apoint the tungstenium electrode when it is operating with the TIG process. |                                       |                                      |                                    |         |