

# BLUE MAX<sup>®</sup> MIG 317L

Stainless ▪ AWS ER317L

## KEY FEATURES

- Weld deposit similar to 316L with high molybdenum content for increased corrosion resistance
- Not suitable for structural service above 400°C (752°F) or for cryogenic applications

## WELDING POSITIONS

All

## SHIELDING GAS

98% Ar / 2% O<sub>2</sub>

## CONFORMANCES

**AWS A5.9/A5.9M:** ER317L  
**ISO 14343: 2009:** (18 15 3 L)

## TYPICAL APPLICATIONS

- Food Processing
- Chemical Processing Plants
- Condensers
- Petrochemical
- Paper Making
- Designed for welding 317L and alloys with similar composition in high corrosive environments

## DIAMETERS / PACKAGING

Diameter in (mm)	33 lb (15 kg) PLW Steel Spool
0.035 (0.9)	ED035116
0.045 (1.1)	ED035117
1/16 (1.6)	ED035119

## WIRE COMPOSITION<sup>(1)</sup> – As Required per AWS A5.9/A5.9M

	%C	%Cr	%Ni	%Mo	%Mn
<b>Requirements</b> AWS ER317L	0.03 max.	18.5 - 20.5	13.0 - 15.0	3.0 - 4.0	1.0 - 2.5
<b>Typical Results<sup>(2)</sup></b>	0.01	18.9	13.7	3.5	1.4
	%Si	%P	%S	%Cu	
<b>Requirements</b> AWS ER317L	0.30 - 0.65	0.03 max	0.03 max	0.75 max	
<b>Typical Results<sup>(2)</sup></b>	0.45	0.01	0.008	0.08	

## TYPICAL OPERATING PROCEDURES

Diameter in (mm)	Voltage (volts)	Amperage	Gas Flow	Gas
0.035 (0.9)	26-29	160-210	30-50 CFH	98% Ar / 2% O <sub>2</sub>
0.045 (1.1)	28-32	180-250		
1/16 (1.6)	29-33	200-280		

<sup>(1)</sup>Typical wire composition. <sup>(2)</sup>See test results disclaimer

### IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED

Fumes from the normal use of some welding products can contain significant quantities of components - such as chromium and manganese - which can lower the 5.0 mg/m<sup>3</sup> maximum exposure guideline for general welding fume.

BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.

*Material Safety Data Sheets (MSDS) and Certificates of Conformance are available on our website at [www.lincolnelectric.com](http://www.lincolnelectric.com)*

#### TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

#### CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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