



**MANUFACTURERS OF A DIVERSE RANGE OF  
ADVANCED WELDING CONSUMABLES**

**SECTION  
13**

WI-0304 DS171 NSB-317LR, Rev. 0, Date 01.09.2008

<b>NSB-317LR</b>	<b>FILLER ROD FOR WELDING LOW-CARBON AUSTENITIC STAINLESS STEELS CONTAINING A NOMINAL 19Cr-13Ni- 3.5Mo</b>										<b>DATA SHEET NO. 171</b>		
	SPECIFICATION			AWS A5.9			JIS Z 3321			BS EN 12072			
CLASSIFICATION			ER317L			Y317L			W 19 13 4 L				
WELD METAL ANALYSIS COMPOSITION % BY Wt.			C	Cr	Ni	Mo	Mn	Si	P	S	Cu	Fe	N
MIN			-	18.5	13	3.0	1.0	0.30	-	-	-		
MAX			0.03	20.5	15	4.0	2.5	0.65	0.03	0.03	0.75		
TYPICAL			0.01	19	14	3.2	1.8	0.4	0.02	0.001	0.15	Bal.	0.02
WELD METAL PROPERTIES (ALL WELD METAL)			<u>PROPERTY</u>		<u>UNITS</u>	<u>MIN</u>	<u>TYPICAL</u>		<u>OTHERS</u>				
			Tensile strength		N/mm <sup>2</sup>	520	630						
			0.2% Proof stress		N/mm <sup>2</sup>	-	460						
			Elongation on 4d		%	30	38						
Impact energy 20 °C		J	-	60									
OTHER DATA			Argon mainly use as shielding gas										
RELATED PRODUCTS			Please contact our Technical Department for detail.										