



Supplier of Welding Alloys

Stainless Steel Flux Cored Wire

Oxford Alloy® 317LT-1

SPECIFICATIONS

AWS 5.22
ASME SFA 5.22

CLASSIFICATIONS

AWS E317LT1-1/T1-4
UNS W31735

DESCRIPTION / APPLICATION

Oxford Alloy E317LT1-1/T1-4 is recommended for welding type 317 and 317L stainless steel to give a maximum of 0.04% Carbon in the weld deposit. The higher molybdenum content, as compared to type 316L, further reduces susceptibility to pitting corrosion. This flux cored wire is used in the pulp and paper industry and in other severe corrosion applications involving sulfuric and sulfurous acids and their salts. Oxford Alloy E317LT1-1/T1-4 was developed for out-of-position welding. This flux cored wire will deposit out-of-position welds at substantially higher welding currents than other stainless steel flux cored wires, resulting in a higher deposition rate. The slag is self-peeling and minimizes cleanup. Oxford Alloy 317LT1-1/T1-4 was formulated for use with 75% Argon/25% CO² shielding gas; however, straight CO² may also be used. The 75/25 mixture will produce a smooth arc with virtually no spatter and slightly higher yield and tensile strengths than CO². The mechanical properties and deposit analysis will meet AWS 5.22 specifications with either gas.

AWS Chemical Composition						
C	Mn	Si	Cr	Ni	Mo	P
0.04 max	0.5-2.5	1.0 max	18.0-21.0	12.0-14.0	3.0-4.0	0.04 max
S	Cu					
0.03 max	0.5 max					

TYPICAL MECHANICAL PROPERTIES

Tensile strength: 91,350 psi 630 MPa

Yield strength: 68,150 psi 470 MPa

Elongation: 33%

Please contact our sales department for more information at 800-562-3355 or 225-273-4800.

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