Oxford Alloy® 317LT1-1/4

AWS E317LT1-1/T1-4 • Stainless Steel

Key Features

- Designed for all-position welding
- Provides superior weld performance and enhanced operator appeal.
- Hermetically sealed packaging to ensure freshness.

Conformances

AWS/ASME SFA 5.22
E317LT1-1/T1-4
UNS W31735

Chemical Composition - As required per AWS 5.22						
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	0.75 max					

Mechanical Properties - As required by AWS 5.22				
	Tensile Strength MPa (ksi)	Yield Strength MPa (ksi)	Elongation %	Charpy V-Notch J (ft-lbf) @ 20 °C (68°F)
AWS Requirements	520 (75) min	Not Specified	20 min	Not Specified
Typical Results - As welded	630 (91)	470 (68)	33	49 (36)

Recommended Shielding Gas

100% CO_2
75% Argon / 25% CO_2

Typical Welding Parameters								
Diameter	.045 (1.14mm)				1/16" (1.6mm)			
Amperage	130	165	190	220	170	210	250	300
Voltage	25	26	28	30	25	27	28	29
Wire Feed speed (in/min)	227	341	445	567	154	193	243	321
Deposition rate (lbs/hr)	4.25	6.14	8.08		5.34	6.89	8.57	11.43
% Efficiency	84.0	83.0	84.0	84.0	83.0	82.5	83.0	83.0

The ESO (Electrical Stick Out) is ½" – 1". DCEP (electrode positive) is specified. When using 75% Argon / 25% CO_2 mixture, decrease voltage by as much as 2 volts.

Diameters & Packaging					
Oxford Alloys USA			**Oxford Alloys Asia Pacific**		
Diameter (in)	**Spool Dimension (in)**	**Spool Weight (lbs)**	**Diameter (mm)**	**Spool Dimension (mm)**	**Spool Weight (kgs)**
.045	12	33 lb spool	1.2	300	15 kg spool
1/16	12	33 lb spool	1.6	300	15 kg spool

Actual test results may vary. Refer test result disclaimer on page 160.