

Stainless steel Rutile electrode

STARBLAZE PRIME 317

Classification:

AWS A5.4 : E 317 - 16

Werkstoff Nr: 1.4438

DIN EN 1600 : E 19 13 4 N R 32

**Description and
Applications:**

Rutile semi-basic stainless steel electrode suitable for the welding of austenitic stainless steels with 16-20% Cr, 10-14% Ni and 3-4% Mo. (AISI 317). The use of these steels are limited to corrosion conditions in the presence of sulphuric and sulphurous acid and their salts. Excellent weldability, smooth arc, finely rippled weld bead, self releasing slag.

Base Materials:

Stainless steels for general use:

Material no.	Steel
1.4434	X2 CrNiMoN18-12-4
1.4438	X2CrNiMo18-15-4
1.4429	X2 CrNiMoN17-13-3
	AISI 317L, – 317LN

**Typical weld
metal Chemical
Composition (%)**

C	Mn	Si	S	P	Cr	Ni	Mo	Ferrite
0.045	0.80	0.85	0.012	0.018	19.50	13.00	3.50	5 - 8

**All weld metal
Mechanical
properties
(Typical)**

Yield strength R _p (N/mm ²)	Tensile strength R _m (N/mm ²)	Elongation A ₅ (%)	Charpy Impact value ISO-V J + 20°C
> 400	590	36	50

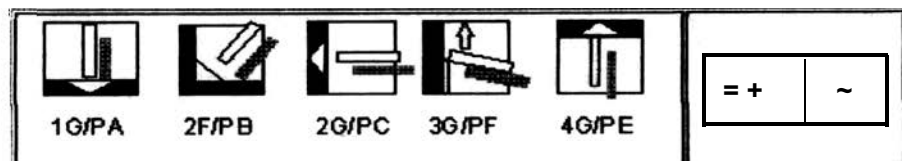
Amperes (A)

2.50mm	3.15mm	4.00mm	5.00mm
50-80	80-110	120-150	150-180

Welding instruction

Redrying 1 h at 300° C, if necessary. Interpass temperature: <200°C.

Welding positions



Stellaris Specialities India Ltd.

(Division: StarBlaze India)

GST No.: 06AAICS2482B1ZK / Legal Metrology No.: GOI/DL/2022/4850

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