


KOBELCO FCW Data Sheet 14
DW-317L
**Classification : AWS A5.22 E317LT0-1
 AWS A5.22 E317LT0-4**
All-Weld-Metal (100% CO₂)**14-1. Chemical Composition**

Unit : wt%

	C	Mn	Si	P	S	Ni	Cr	Mo	N
DW-317L	0.024	1.03	0.43	0.016	0.012	12.74	18.95	3.24	0.063
E317LTX-X	≤0.04	0.5/2.5	≤1.0	10.04	10.03	1 1/14	18/21	3/4	---

14-2. Ferrite Content

	Shaeffler Diagram (%)	Delong Diagram (FN)	1992-WRC Diagram (FN)
As Welded	8.1	9.2	7.4

14-3. Tensile Test

	0.2% Yield Strength (psi)	Tensile Strength (psi)	Elongation (%)	Reduction of Area (%)
DW-317L	59,706	88,615	36	45
E317LTX-X	---	275,000	≥20	---

Note: Test was completed in the as-welded condition at room temperature.

14-4. Corrosion Test**5% Sulfuric Acid Test**

	Test Results (g/m ² •hr)
As Welded	5.9

Copper Sulfate Sulfuric Acid Test

PWHT : 1,200°F x 2hr

Bend Test Results : No Defect