ALLEGHENY LUDLUM
An Allegheny Teledyne Company

# Technical Data BLUE SHEET

Allegheny Ludlum Corporation ◆ Pittsburgh, PA

# Stainless Steels

## Chromium-Nickel-Molybdenum

## Types 316 (S31600), 316L (S31603), 317 (S31700), 317L (S31703)

## GENERAL PROPERTIES

Allegheny Ludlum Types 316 (UNS S31600), 316L (S31603), 317 (S31700) and 317L (S31703) are molybdenum-bearing austenitic stainless steels which are more resistant to general corrosion and pitting/crevice corrosion than the conventional chromium-nickel austenitic stainless steels such as Type 304. These alloys also offer higher creep, stress-to-rupture and tensile strength at elevated temperature. Types 317 and 317L containing 3 to 4% molybdenum are preferred to Types 316 or 316L which contain 2 to 3% molybdenum in applications requiring enhanced pitting and general corrosion resistance. There is a 316LM alloy, a 2.5% minimum Mo version of Type 316L stainless steel, available only by special order.

Austenitic stainless steels with higher molybdenum or molybdenum plus nitrogen content which provide even greater resistance to pitting, crevice corrosion and general corrosion are also available in flat-rolled products from Allegheny Ludlum. These include AL 317LX™ (UNS S31725, 4-5% Mo), AL 317LXN™ (S31726, 4-5% Mo and 0.1-0.2% N), and AL-6XN® (N08367, 6-7% Mo and 0.18-0.25% N) alloys. Properties of these alloys are described in separate technical data publications available from Allegheny Ludlum.

In addition to excellent corrosion resistance and strength properties, the Types 316, 316L, 317 and 317L Cr-Ni-Mo alloys also provide the excellent fabricability and formability which are typical of the austenitic stainless steels.

Allegheny Ludlum Types 316, 316L, 317 and 317L are available in the form of sheet, strip and plate to ASTM A240 and ASME SA-240 and other pertinent specifications.

Consult with the Allegheny Ludlum Technical Center for technical information not provided in this publication and for further details on the data contained herein.

## CHEMICAL COMPOSITION

Chemical composition as represented by ASTM A240 and ASME SA-240 specifications are indicated in the table below.

| Element | Percentage by Weight (maximum unless range is specified) | | | |
|---|---|---|---|---|
| | Type 316 | Type 316L | Type 317 | Type 317L |
| Carbon | 0.08 | 0.030 | 0.08 | 0.030 |
| Manganese | 2.00 | 2.00 | 2.00 | 2.00 |
| Silicon | 0.75 | 0.75 | 0.75 | 0.75 |
| Chromium | 16.00 – 18.00 | 16.00 – 18.00 | 18.00 – 20.00 | 18.00 – 20.00 |
| Nickel | 10.00 – 14.00 | 10.00 – 14.00 | 11.00 – 15.00 | 11.00 – 15.00 |
| Molybdenum | 2.00 – 3.00 | 2.00 – 3.00 | 3.00 – 4.00 | 3.00 – 4.00 |
| Phosphorus | 0.045 | 0.045 | 0.045 | 0.045 |
| Sulfur | 0.030 | 0.030 | 0.030 | 0.030 |
| Nitrogen | 0.10 | 0.10 | 0.10 | 0.10 |
| Iron | Bal. | Bal. | Bal. | Bal. |

*Data are typical and should not be construed as maximum or minimum values for specification or for final design. Data on any particular piece of material may vary from those shown herein.*

™Trademark of ATI Properties, Inc
®Registered Trademark of ATI Properties, Inc.

UES Promura | +61 3 9547 5833 | sales@uespromura.com.au
10-12 McWilliam Street, Springvale VIC 3171 | uespromura.com.au
Distributor reference copy. Technical / issuer particulars retained; contact links localised.

## RESISTANCE TO CORROSION

### General Corrosion

Types 316, 316L, 317 and 317L are more resistant to atmospheric and other mild types of corrosion than the 18-8 stainless steels. In general, media that do not corrode 18-8 stainless steels will not attack these molybdenum-containing grades. One known exception is highly oxidizing acids such as nitric acid to which the molybdenum-bearing stainless steels are less resistant.

Types 316 and 317 are considerably more resistant than any of the other chromium-nickel types to solutions of sulfuric acid. At temperatures as high as 120°F (49°C), Types 316 and 317 are resistant to concentrations of this acid up to 5 percent. At temperatures under 100°F (38°C), both types have excellent resistance to higher concentrations. Service tests are usually desirable as operating conditions and acid contaminants may significantly affect corrosion rate. Where condensation of sulfur-bearing gases occurs, these alloys are much more resistant than other types of stainless steels. In such applications, however, the acid concentration has a marked influence on the rate of attack and should be carefully determined.

The molybdenum-bearing Types 316 and 317 stainless steels also provide resistance to a wide variety of other environments. As shown by the laboratory corrosion data below, these alloys offer excellent resistance to boiling 20% phosphoric acid. They are also widely used in handling hot organic and fatty acids. This is a factor in the manufacture and handling of certain food and pharmaceutical products where the molybdenum-containing stainless steels are often required in order to minimize metallic contamination.

Generally, the Type 316 and 316L grades can be considered to perform equally well for a given environment. The same is true for Type 317 and 317L. A notable exception is in environments sufficiently corrosive to cause intergranular corrosion of welds and heat-affected zones on susceptible alloys. In such media, the Type 316L and 317L grades are preferred over Type 316 and 317, respectively, for the welded condition since low carbon levels enhance resistance to intergranular corrosion.

**General Corrosion in Boiling Solutions**

| Boiling Test Solution | Corrosion Rate, Mils/Yr (mm/a) | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| | Type 316L | | | | Type 317L | | | |
| | Base Metal | | Welded | | Base Metal | | Welded | |
| 20% Acetic Acid | 0.12 | (0.003) | 0.12 | (0.003) | 0.48 | (0.012) | 0.36 | (0.009) |
| 45% Formic Acid | 23.4 | (0.594) | 20.9 | (0.531) | 18.3 | (0.465) | 24.2 | (0.615) |
| 1% Hydrochloric Acid | 0.96 | (0.024) | 63.6 | (1.615) | 54.2 | (1.377) | 51.4 | (1.306) |
| 10% Oxalic Acid | 48.2 | (1.224) | 44.5 | (1.130) | 44.9 | (1.140) | 43.1 | (1.094) |
| 20% Phosphoric Acid | 0.60 | (0.015) | 1.08 | (0.027) | 0.72 | (0.018) | 0.60 | (0.015) |
| 10% Sulfamic Acid | 124.2 | (3.155) | 119.3 | (3.030) | 94.2 | (2.393) | 97.9 | (2.487) |
| 10% Sulfuric Acid | 635.3 | (16.137) | 658.2 | (16.718) | 298.1 | (7.571) | 356.4 | (9.053) |
| 10% Sodium Bisulfate | 71.5 | (1.816) | 56.2 | (1.427) | 55.9 | (1.420) | 66.4 | (1.687) |
| 50% Sodium Hydroxide | 77.6 | (1.971) | 85.4 | (2.169) | 32.8 | (0.833) | 31.9 | (0.810) |

*Data are typical and should not be construed as maximum or minimum values for specification or for final design. Data on any particular piece of material may vary from those shown herein.*



UES Promura | +61 3 9547 5833 | sales@uespromura.com.au
10-12 McWilliam Street, Springvale VIC 3171 | uespromura.com.au
Distributor reference copy. Technical / issuer particulars retained; contact links localised.

## Pitting/Crevice Corrosion

Resistance of austenitic stainless steels to pitting and/or crevice corrosion in the presence of chloride or other halide ions is enhanced by higher chromium (Cr), molybdenum (Mo), and nitrogen (N) content. A relative measure of pitting resistance is given by the PREN (Pitting Resistance Equivalent, including Nitrogen) calculation, where $PRE_N$ = Cr+3.3Mo+16N. The $PRE_N$ of Type 316 and 316L (24.2) is better than that of Type 304 ($PRE_N$=19.0), reflecting the better pitting resistance which T316 (or T316L) offers due to its Mo content. Type 317 (and 317L), with 3.1% Mo and $PRE_N$=29.7, offers even better resistance to pitting than the T316 alloys. As shown by the following table of data, best resistance to pitting is provided by the AL-6XN® alloy which contains 6.2% Mo and 0.22% N and has a $PRE_N$ of 44.5. CCCT (Critical Crevice Corrosion Temperature) and CPT (Critical Pitting Temperature) data for the alloys, as measured by ASTM G48 ferric chloride tests, are also shown. The measured CCCT and CPT data correlate well with the calculated $PRE_N$ numbers.

Type 304 stainless steel is considered to resist pitting and crevice corrosion in waters containing up to about 100 ppm chloride. The Mo-bearing Type 316 and Type 317 alloys on the other hand, will handle waters with up to about 2000 and 5000 ppm chloride, respectively. Although these alloys have been used with mixed success in seawater (19,000 ppm chloride) they are not recommended for such use. The AL-6XN® alloy with 6.2% Mo and 0.22% N is specifically designed for use in seawater. The Type 316 and 317 alloys are considered to be adequate for some marine environment applications such as boat rails and hardware, and facades of buildings near the ocean which are exposed to salt spray. The Types 316 and 317 stainless steels all perform without evidence of corrosion in the 100-hour, 5% salt spray (ASTM B117) test.

**Pitting and Crevice Corrosion Indices**

| Alloy | Composition (Weight Percent) | | | $PRE_N$ [1] | CCCT [2] °F (°C) | CPT [3] °F (°C) |
|---|---|---|---|---|---|---|
| | Cr | Mo | N | | | |
| Type 304 | 18.0 | -- | 0.06 | 19.0 | <27.5<br>(<-2.5) | --<br>-- |
| Type 316 | 16.5 | 2.1 | 0.05 | 24.2 | 27.5<br>(-2.5) | 59<br>(15.0) |
| Type 317 | 18.5 | 3.1 | 0.06 | 29.7 | 35.0<br>(1.7) | 66<br>(18.9) |
| AL 904L™ | 20.5 | 4.5 | 0.05 | 36.2 | 68.0<br>(20.0) | 104<br>(40.0) |
| AL-6XN® | 20.5 | 6.2 | 0.22 | 44.5 | 110<br>(43.0) | 149<br>(65) |

[1]Pitting Resistance Equivalent, including Nitrogen, $PRE_N$=Cr+3.3Mo+16N
[2]Critical Crevice Corrosion Temperature, CCCT, based on ASTM G-48B (6%$FeCl_3$ for 72 hr, with crevices)
[3]Critical Pitting Temperature, CPT, based on ASTM G-48A (6%$FeCl_3$ for 72 hr)

*Data are typical and should not be construed as maximum or minimum values for specification or for final design. Data on any particular piece of material may vary from those shown herein.*



UES Promura | +61 3 9547 5833 | sales@uespromura.com.au
10-12 McWilliam Street, Springvale VIC 3171 | uespromura.com.au
Distributor reference copy. Technical / issuer particulars retained; contact links localised.

## Intergranular Corrosion

Both Types 316 and 317 are susceptible to precipitation of chromium carbides in grain boundaries when exposed to temperatures in the 800°F to 1500°F (427°C to 816°C) range. Such “sensitized” steels are subject to intergranular corrosion when exposed to aggressive environments. Where short periods of exposure are encountered, however, such as in welding, Type 317 with its higher chromium and molybdenum content is more resistant to intergranular attack than Type 316 for applications where light gage material is to be welded. Heavier cross sections over 7/16 inch (11.1 mm) usually require annealing even when Type 317 is used.

For applications where heavy cross sections cannot be annealed after welding or where low temperature stress relieving treatments are desired, the low carbon Types 316L and 317L are available to avoid the hazard of intergranular corrosion. This provides resistance to intergranular attack with any thickness in the as-welded condition or with short periods of exposure in the 800-1500°F (427-826°C) temperature range. Where vessels require stress relieving treatment, short treatments falling within these limits can be employed without affecting the normal excellent corrosion resistance of the metal. Accelerated cooling from higher temperatures for the “L” grades is not needed when very heavy or bulky sections have been annealed.

Types 316L and 317L possess the same desirable corrosion resistance and mechanical properties as the corresponding higher carbon Types 316 and 317, and offer an additional advantage in highly corrosive applications where intergranular corrosion is a hazard. Although the short duration heating encountered during welding or stress relieving does not produce susceptibility to intergranular corrosion, it should be noted that continuous or prolonged exposure at 800-1500°F (427-816°C) can be harmful from this standpoint with Types 316L and 317L. Also stress relieving between 1100-1500°F (593-816°C) may cause some slight embrittlement of these types.

**Intergranular Corrosion Tests**

| ASTM A 262 Evaluation Test | Corrosion Rate, Mils/Yr (mm/a) | | |
|---|---|---|---|
| | Type 316 | Type 316L | Type 317L |
| Practice B<br>Base Metal<br>Welded | 36 (0.9)<br>41 (1.0) Intergranular Corrosion | 26 (0.7)<br>23 (0.6) | 21 (0.5)<br>24 (0.6) |
| Practice E<br>Base Metal<br>Welded | No Fissures on Bend<br>Some Fissures on Weld<br>(unacceptable) | No Fissures<br>No Fissures | No Fissures<br>No Fissures |
| Practice A<br>Base Metal<br>Welded | Step Structure<br>Ditched<br>(unacceptable) | Step Structure<br>Step Structure | Step Structure<br>Step Structure |

## Stress Corrosion Cracking

Austenitic stainless steels are susceptible to stress corrosion cracking (SCC) in halide environments. Although the Types 316 and 317 alloys are somewhat more resistant to SCC than the 18 Cr-8 Ni alloys because of their molybdenum content, they still are quite susceptible. Conditions which produce SCC are: (1) presence of halide ion (generally chloride), (2) residual tensile stresses, and (3) temperatures in excess of about 120°F (49°C).

*Data are typical and should not be construed as maximum or minimum values for specification or for final design. Data on any particular piece of material may vary from those shown herein.*



UES Promura | +61 3 9547 5833 | sales@uespromura.com.au
10-12 McWilliam Street, Springvale VIC 3171 | uespromura.com.au
Distributor reference copy. Technical / issuer particulars retained; contact links localised.

Stresses result from cold deformation or thermal cycles during welding. Annealing or stress relieving heat treatments may be effective in reducing stresses, thereby reducing sensitivity to halide SCC. Although the low carbon "L" grades offer no advantage as regards SCC resistance, they are better choices for service in the stress relieved condition in environments which might cause intergranular corrosion.

**Halide (Chloride) Stress Corrosion Tests**

| Test | U-Bend (Highly Stressed) Samples | | |
|---|---|---|---|
| | Type 316 | Type 316L | Type 317L |
| 42% Magnesium Chloride, Boiling | Cracked, 4-24 hours | Cracked, 21-45 hours | Cracked, 72 hours |
| 33% Lithium Chloride, Boiling | Cracked, 48-569 hours | Cracked, 21-333 hours | Cracked 22-72 hours |
| 26% Sodium Chloride, Boiling | Cracked, 530-940 hours | No Cracks 1002 hours | Cracked 1000 hours |
| 40% Calcium Chloride, Boiling | Cracked, 144-1000 hours | -- | -- |
| Seacoast Exposure, Ambient Temperature | No cracking | No Cracking | No Cracking |

## RESISTANCE TO OXIDATION

The Type 316 and 317 alloys exhibit excellent resistance to oxidation and a low rate of scaling in air atmospheres at temperatures up to 1600-1650°F (871-899°C). The performance of Type 316 is generally somewhat inferior to that of Type 304 stainless steel which has slightly higher chromium content (18% vs. 16% for Type 316). Since the rate of oxidation is greatly influenced by the atmosphere encountered and by operating conditions, no actual data can be presented which are applicable to all service conditions. For further information contact the Allegheny Ludlum Technical Center.

## PHYSICAL PROPERTIES

### Structure

When properly annealed, Types 316 and 317 are primarily austenitic. Small quantities of ferrite may or may not be present. When slowly cooled or held in the temperature range 800-1500°F (427-816°C), carbides are precipitated and the structure consists of austenite plus carbides.

**Melting Range:** 2540-2630°F (1390-1440°C)

**Density:** 0.29 lb/in$^3$ (8.027 g/cm$^3$)

**Modulus of Elasticity in Tension:** 29 x 10$^6$ psi (200 Gpa)

**Modulus of Shear:** 11.9 x 10$^6$ psi (82 Gpa)

**Coefficient of Linear Thermal Expansion**

| Temperature Range | | Coefficients | |
|---|---|---|---|
| °F | °C | in/in/°F | cm/cm/°C |
| 68 - 212 | 20 - 100 | 9.2x10$^{-6}$ | 16.5x10$^{-6}$ |
| 68 - 932 | 20 - 500 | 10.1x10$^{-6}$ | 18.2x10$^{-6}$ |
| 68 - 1832 | 20 - 1000 | 10.8x10$^{-6}$ | 19.5x10$^{-6}$ |

**Thermal Conductivity**

| Temperature Range | | Btu•in/ hr•ft$^2$•°F | W/m·K |
|---|---|---|---|
| °F | °C | | |
| 68-212 | 20-100 | 100.8 | 14.6 |

The overall heat transfer coefficient of metals is determined by factors in addition to thermal conductivity of the metal. The ability of the 18-8 stainless grades to maintain clean surfaces often allows better heat transfer than other metals having higher thermal conductivity. Consult the Allegheny Ludlum Technical Center for further information.

**Specific Heat**

| °F | °C | Btu/lb•°F | J/kg•K |
|---|---|---|---|
| 68 | 20 | 0.108 | 450 |
| 200 | 93 | 0.116 | 485 |

**Electrical Resistivity**

| Type | Value at 68°F (20°C) | |
|---|---|---|
| | Microhm-in. | Microhm-cm. |
| 316 | 29.1 | 74.0 |
| 317 | 31.1 | 79.0 |

*Data are typical and should not be construed as maximum or minimum values for specification or for final design. Data on any particular piece of material may vary from those shown herein.*



UES Promura | +61 3 9547 5833 | sales@uespromura.com.au
10-12 McWilliam Street, Springvale VIC 3171 | uespromura.com.au
Distributor reference copy. Technical / issuer particulars retained; contact links localised.

### Magnetic Permeability

Austenitic stainless steels are nonmagnetic in the annealed, fully austenitic condition. The magnetic permeability of the Types 316 and 317 alloys in the annealed condition is generally less than 1.02 at 200 H (oersteds). Permeability values for cold deformed material vary with composition and the amount of cold deformation, but are usually higher than that for annealed material. Typical data are available on request from Allegheny Ludlum Technical Center.

## MECHANICAL PROPERTIES

### Room Temperature Tensile Properties

Minimum mechanical properties for annealed Types 316, 316L, 317 and 317L austenitic stainless steel plate, sheet and strip as required by ASTM specifications A240 and ASME specification SA-240, are shown below.

| Property | Minimum Mechanical Properties Required by ASTM A 240, and ASME SA-240 | | | |
|---|---|---|---|---|
| | Type 316 (S31600) | Type 316L (S31603) | Type 317 (S31700) | Type 317L (S31703) |
| Yield Strength 0.2% Offset psi (MPa) | 30,000 (205) | 25,000 (170) | 30,000 (205) | 30,000 (205) |
| Ultimate Tensile Strength psi (MPa) | 75,000 (515) | 70,000 (485) | 75,000 (515) | 75,000 (515) |
| Percent Elongation in 2 in. or 51 mm | 40.0 | 40.0 | 35.0 | 40.0 |
| Hardness, Max. Brinell (RB) | 217 (95) | 217 (95) | 217 (95) | 217 (95) |

### Effect of Cold Work

Deformation of austenitic alloys at room or slightly elevated temperature produces an increase in strength accompanied by a decrease in elongation value. Representative room temperature properties of Types 316, 316L, 317 and 317L sheet in the annealed and cold worked conditions are shown in the following tables. Types 316, 316L, 317, and 317L flat rolled products are generally available in the annealed condition. Data for cold rolled strip are included as a guide to indicate the effects of cold deformation on properties during fabrication operations such as drawing and forming.

### Analyses Tested (See footnote)

| Type | C | Mn | Cr | Ni | Mo |
|---|---|---|---|---|---|
| 316 | 0.051 | 1.65 | 17.33 | 13.79 | 2.02 |
| 316L | 0.015 | 1.84 | 16.17 | 10.16 | 2.11 |
| 317 | 0.062 | 1.66 | 18.60 | 13.95 | 3.30 |
| 317L | 0.025 | 1.72 | 18.48 | 12.75 | 3.15 |

*Data are typical and should not be construed as maximum or minimum values for specification or for final design. Data on any particular piece of material may vary from those shown herein.*



UES Promura | +61 3 9547 5833 | sales@uespromura.com.au
10-12 McWilliam Street, Springvale VIC 3171 | uespromura.com.au
Distributor reference copy. Technical / issuer particulars retained; contact links localised.

## Type 316 - 0.040-inch (1.0 mm) thick

| Percent Cold Reduction | Yield Strength 0.2% Offset | | Ultimate Tensile Strength | | Elongation, Percent in 2 in. (51 mm) |
|---|---|---|---|---|---|
| | psi | MPa | psi | MPa | |
| **Annealed** | 38,500 | 265 | 84,600 | 583 | 61.0 |
| 10 | 71,300 | 492 | 94,500 | 652 | 40.0 |
| 20 | 98,600 | 680 | 111,600 | 769 | 21.0 |
| 31 | 119,500 | 824 | 133,000 | 917 | 11.0 |
| 49 | 135,800 | 936 | 148,000 | 1,020 | 6.0 |
| 60 | 150,300 | 1,036 | 169,600 | 1,170 | 3.5 |

## Type 316L - 0.059-inch (1.5-mm) thick

| Percent Cold Reduction | Yield Strength 0.2% Offset | | Ultimate Tensile Strength | | Elongation, Percent in 2 in. (51 mm) |
|---|---|---|---|---|---|
| | psi | MPa | psi | MPa | |
| **Annealed** | 43,300 | 299 | 88,750 | 612 | 54.0 |
| 10 | 77,550 | 535 | 101,800 | 702 | 38.3 |
| 20 | 101,000 | 696 | 121,750 | 839 | 22.8 |
| 31 | 119,300 | 822 | 144,200 | 994 | 15.3 |
| 49 | 145,000 | 1,000 | 174,500 | 1,203 | 7.8 |
| 60 | 166,000 | 1,144 | 194,450 | 1,341 | 5.8 |

## Type 317 - 0.036-inch (0.9 mm) thick

| Percent Cold Reduction | Yield Strength 0.2% Offset | | Ultimate Tensile Strength | | Elongation, Percent in 2 in. (51 mm) |
|---|---|---|---|---|---|
| | psi | MPa | psi | MPa | |
| **Annealed** | 38,300 | 264 | 85,500 | 588 | 55.0 |
| 15 | 70,000 | 483 | 112,000 | 772 | 29.0 |
| 30 | 116,000 | 800 | 130,700 | 901 | 13.0 |
| 45 | 138,500 | 955 | 154,900 | 1,068 | 7.0 |
| 60 | 151,400 | 1,044 | 171,500 | 1,182 | 4.0 |

*Data are typical and should not be construed as maximum or minimum values for specification or for final design. Data on any particular piece of material may vary from those shown herein.*



UES Promura | +61 3 9547 5833 | sales@uespromura.com.au
10-12 McWilliam Street, Springvale VIC 3171 | uespromura.com.au
Distributor reference copy. Technical / issuer particulars retained; contact links localised.

## Type 317L - 0.105-inch (2.6 mm) thick

| Percent Cold Reduction | Yield Strength 0.2% Offset | | Ultimate Tensile Strength | | Elongation, Percent in 2 in. (51 mm) |
|---|---|---|---|---|---|
| | psi | MPa | psi | MPa | |
| **Annealed** | 48,700 | 336 | 89,050 | 614 | 48.0 |
| 15 | 99,250 | 684 | 112,350 | 775 | 23.3 |
| 30 | 119,250 | 822 | 142,050 | 979 | 15.3 |
| 45 | 140,450 | 967 | 168,100 | 1,159 | 9.3 |
| 60 | 148,850 | 1,026 | 184,050 | 1,269 | 7.5 |

## Elevated Temperature Tensile Properties

Representative short time elevated temperature tensile properties for Types 316, 316L, 317 and 317L of the following analyses are shown below.

**Analyses Tested** (See footnote)

| Type | C | Mn | Cr | Ni | Mo |
|---|---|---|---|---|---|
| 316 | 0.080 | 1.50 | 17.78 | 12.50 | 2.46 |
| 316L | 0.015 | 1.84 | 16.17 | 10.16 | 2.11 |
| 317 | 0.061 | 1.30 | 19.18 | 14.19 | 3.57 |
| 317L | 0.025 | 1.72 | 18.48 | 12.75 | 3.15 |

## Type 316 (Bar specimen tension test procedures)

| Test Temperature | | Yield Strength 0.2% Offset | | Ultimate Tensile Strength | | Elongation, Percent in 2 in. (51 mm) | Reduction in Area, Percent |
|---|---|---|---|---|---|---|---|
| °F | °C | psi | MPa | psi | MPa | | |
| 68 | 20 | 42,400 | 292 | 82,400 | 568 | 68.0 | 81.0 |
| 200 | 93 | — | — | 75,600 | 521 | 54.0 | 80.0 |
| 400 | 204 | — | — | 71,400 | 492 | 51.0 | 78.0 |
| 600 | 316 | — | — | 71,150 | 491 | 48.0 | 71.0 |
| 800 | 427 | 26,500 | 183 | 71,450 | 493 | 47.0 | 71.0 |
| 1000 | 538 | 23,400 | 161 | 68,400 | 472 | 55.0 | 70.0 |
| 1200 | 649 | 22,600 | 156 | 50,650 | 349 | 24.0 | 32.0 |
| 1400 | 760 | — | — | 30,700 | 212 | 26.0 | 35.0 |
| 1600 | 871 | — | — | 18,000 | 124 | 47.0 | 40.0 |

*Data are typical and should not be construed as maximum or minimum values for specification or for final design. Data on any particular piece of material may vary from those shown herein.*



UES Promura | +61 3 9547 5833 | sales@uespromura.com.au
10-12 McWilliam Street, Springvale VIC 3171 | uespromura.com.au
Distributor reference copy. Technical / issuer particulars retained; contact links localised.

## Type 316L (Sheet Specimen Tension Test Procedures)

| Test Temperature | | Yield Strength 0.2% Offset | | Ultimate Tensile Strength | | Elongation, Percent in 2 in. (51 mm) |
|---|---|---|---|---|---|---|
| °F | °C | psi | MPa | psi | MPa | |
| 68 | 20 | 43,850 | 302 | 88,200 | 608 | 56.8 |
| 200 | 93 | 36,650 | 252 | 78,250 | 539 | 49.0 |
| 400 | 204 | 32,400 | 223 | 69,000 | 476 | 37.5 |
| 600 | 316 | 28,050 | 193 | 67,450 | 465 | 33.8 |
| 800 | 427 | 26,750 | 184 | 66,000 | 455 | 33.8 |
| 1000 | 538 | 25,900 | 179 | 64,350 | 444 | 36.8 |
| 1200 | 649 | 25,300 | 174 | 54,200 | 374 | 28.3 |
| 1400 | 760 | 22,100 | 152 | 42,000 | 290 | 25.0 |
| 1600 | 871 | 16,800 | 116 | 26,900 | 185 | 50.3 |

## Type 317 (Bar Specimen Tension Test Procedures)

| Test Temperature | | Yield Strength 0.2% Offset | | Ultimate Tensile Strength | | Elongation, Percent in 2 in. (51 mm) | Reduction in Area, Percent |
|---|---|---|---|---|---|---|---|
| °F | °C | psi | MPa | psi | MPa | | |
| 68 | 20 | 36,700 | 292 | 81,800 | 564 | 68.0 | 80.0 |
| 200 | 93 | — | — | 74,100 | 492 | 54.0 | 79.0 |
| 400 | 204 | — | — | 68,900 | 475 | 48.0 | 76.0 |
| 600 | 316 | — | — | 68,950 | 475 | 49.0 | 72.0 |
| 800 | 427 | 21,900 | 151 | 70,200 | 484 | 49.0 | 69.0 |
| 1000 | 538 | 20,200 | 139 | 65,700 | 453 | 52.0 | 68.0 |
| 1200 | 649 | 19,600 | 135 | 49,800 | 343 | — | — |
| 1400 | 760 | — | — | 31,600 | 218 | 33.0 | 37.0 |
| 1600 | 871 | — | — | 18,400 | 127 | 51.0 | 50.0 |

*Data are typical and should not be construed as maximum or minimum values for specification or for final design. Data on any particular piece of material may vary from those shown herein.*



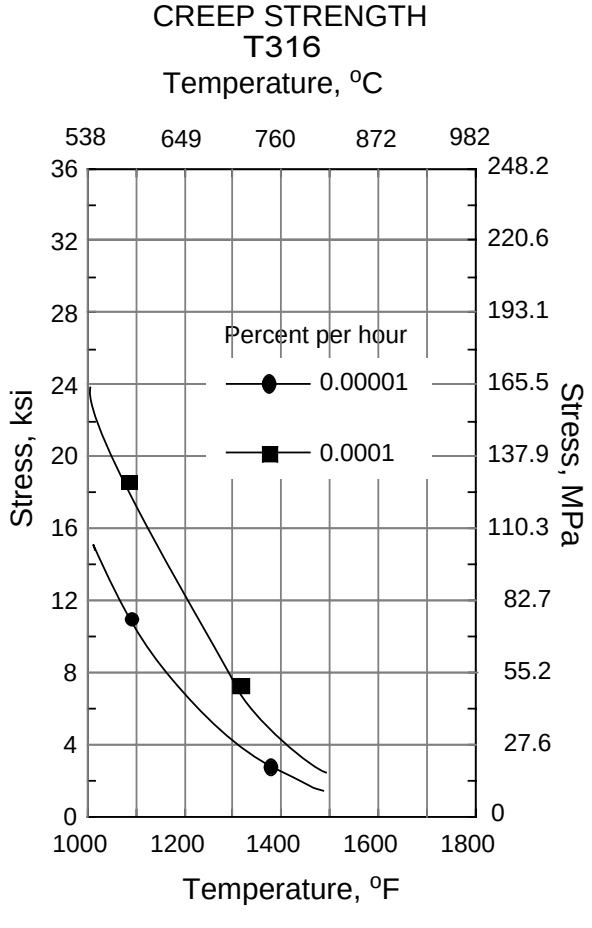
UES Promura | +61 3 9547 5833 | sales@uespromura.com.au
10-12 McWilliam Street, Springvale VIC 3171 | uespromura.com.au
Distributor reference copy. Technical / issuer particulars retained; contact links localised.

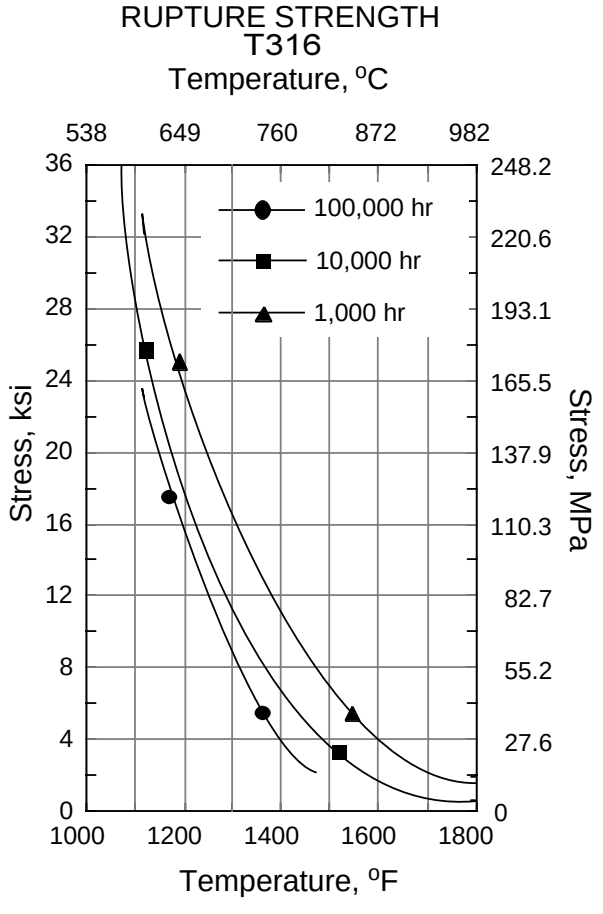
## Type 317L (Sheet Specimen Tension Test Procedures)

| Test Temperature | | Yield Strength 0.2% Offset | | Ultimate Tensile Strength | | Elongation, Percent in 2 in. (51 mm) |
|---|---|---|---|---|---|---|
| °F | °C | psi | MPa | psi | MPa | |
| 68 | 20 | 46,250 | 319 | 88,500 | 610 | 49.8 |
| 200 | 93 | 38,650 | 266 | 80,350 | 554 | 42.8 |
| 400 | 204 | 33,500 | 231 | 73,350 | 506 | 38.8 |
| 600 | 316 | 29,100 | 201 | 70,550 | 486 | 35.3 |
| 800 | 427 | 26,450 | 182 | 69,750 | 481 | 34.3 |
| 1000 | 538 | 25,100 | 173 | 68,400 | 472 | 36.5 |
| 1200 | 649 | 23,650 | 163 | 59,700 | 412 | 31.5 |
| 1400 | 760 | 22,750 | 157 | 45,000 | 310 | 32.8 |
| 1600 | 871 | 19,150 | 132 | 29,050 | 200 | 50.0 |

## Stress Rupture and Creep Properties

At temperatures of about 1000°F (538°C) and higher, creep and stress rupture become considerations for the austenitic stainless steels. Considerable variation in the creep strength and stress rupture strength values is reported by various investigators. Representative data for annealed Type 316 stainless steel are presented below. Values for Type 317 for all practical purposes will be similar.




*Data are typical and should not be construed as maximum or minimum values for specification or for final design. Data on any particular piece of material may vary from those shown herein.*



UES Promura | +61 3 9547 5833 | sales@uespromura.com.au
10-12 McWilliam Street, Springvale VIC 3171 | uespromura.com.au
Distributor reference copy. Technical / issuer particulars retained; contact links localised.

### Impact Resistance

The annealed austenitic stainless steels maintain a high level of impact resistance even at cryogenic temperatures, a property which, in combination with their low temperature strength and fabricability, has led to their extensive use in cryogenic applications. Representative Charpy V-notch impact data for annealed Type 316 at room temperature are shown below.

| Temperature | | Energy Absorbed | |
|---|---|---|---|
| °F | °C | Ft-lb | J |
| 75 | 23 | 65 - 100 | 88 - 134 |

### Fatigue Strength

The fatigue strength or endurance limit is the maximum stress below which material is unlikely to fail in 10 million cycles in air environment. For austenitic stainless steels as a group, the fatigue strength is typically about 35 percent of the tensile strength. Substantial variability in service results is experienced since additional variables such as corrosive conditions, form of stress and mean value, surface roughness, and other factors affect fatigue properties. For this reason, no definitive endurance limit values can be given which are representative of all operating conditions.

## HEAT TREATMENT

### Annealing

The austenitic stainless steels are provided in the mill annealed condition ready for use. Heat treatment may be necessary during or after fabrication to remove the effects of cold forming or to dissolve precipitated chromium carbides resulting from thermal exposures. For the Types 316 and 317 alloys the solution anneal is accomplished by heating in the 1900 to 2150°F (1040 to 1175°C) temperature range followed by air cooling or a water quench, depending on section thickness. Cooling should be sufficiently rapid through the 1500-800°F (816-427°C) range to avoid reprecipitation of chromium carbides and provide optimum corrosion resistance. In every case, the metal should be cooled from the annealing temperature to black heat in less than three minutes.

The Types 316 and 317 alloys cannot be hardened by heat treatment.

### Forging

| | |
|---|---|
| Initial | 2100 - 2200°F (1150 - 1205°C) |
| Finishing | 1700 - 1750°F (927 - 955°C) |

## FABRICATION

The austenitic stainless steels, including the Types 316 and 317 alloys, are routinely fabricated into a variety of shapes ranging from the very simple to very complex. These alloys are blanked, pierced, and formed on equipment essentially the same as used for carbon steel. The excellent ductility of the austenitic alloys allows them to be readily formed by bending, stretching, deep drawing and spinning. However, because of their greater strength and work hardenability, the power requirements for the austenitic grades during forming operations is considerably greater than for carbon steels. Attention to lubrication during forming of the austenitic alloys is essential to accommodate the high strength and galling tendency of these alloys.

### Welding

The austenitic stainless steels are considered to be the most weldable of the stainless steels. They are routinely joined by all fusion and resistance welding processes. Two important considerations for weld joints in these alloys are: (1) avoidance of solidification cracking, and (2) preservation of corrosion resistance of the weld and heat-affected zones.

Fully austenitic weld deposits are more susceptible to cracking during welding. For this reason Types 316, 316L, 317 and 317L “matching” filler metals are formulated to solidify with a small amount of ferrite in the microstructure to minimize cracking susceptibility.

For weldments to be used in the as-welded condition in corrosive environments, it is advisable to utilize the low carbon Types 316L and 317L base metal and filler metals. The higher the carbon level of the material being welded, the greater the likelihood the welding thermal cycles will allow chromium carbide precipitation (sensitization), which could result in intergranular corrosion. The low carbon “L” grades are designed to minimize or avoid sensitization.

*Data are typical and should not be construed as maximum or minimum values for specification or for final design. Data on any particular piece of material may vary from those shown herein.*



UES Promura | +61 3 9547 5833 | sales@uespromura.com.au
10-12 McWilliam Street, Springvale VIC 3171 | uespromura.com.au
Distributor reference copy. Technical / issuer particulars retained; contact links localised.

High-molybdenum weld deposits may experience degraded corrosion resistance in severe environments due to micro-segregation of molybdenum. To overcome this effect, the molybdenum content of the weld filler metal should be increased. For some severe applications for the Type 317 alloys, weld deposits containing 4 percent or more of molybdenum may be desirable. Type 904L (AWS ER 385, 4.5% Mo) or Alloy 625 (AWS ERNiCrMo-3, 9% Mo) filler metals have been used for this purpose.

Be careful to avoid copper or zinc contamination in the weld zone since these elements can form low melting point compounds which in turn can create weld cracking.

### Cleaning

Despite their corrosion resistance, stainless steels need care during fabrication and use to maintain their attractive surface appearance even under normal service conditions.

During welding, it is important that surfaces are clean and that proper inert shielding gases are used. Scale or slag that forms from welding processes should be removed with a stainless steel wire brush. Use of carbon steel wire brushes leaves particles embedded in the surface which will eventually produce rusting. For more severe applications, welded areas should be treated with a descaling solution such as a mixture of nitric and hydrofluoric acids and, subsequently, these should be thoroughly washed off with clean water.

For stainless steel surfaces exposed in light inland industrial or milder service, minimum maintenance is required. Only sheltered areas need occasional washing with pressurized water. In heavy industrial or marine environments, frequent washing is advisable to remove dirt or salt deposits which might cause corrosion and impair the surface appearance of the stainless steel surface.

Stubborn spots and deposits like burned-on food can be removed by scrubbing with a nonabrasive cleaner and fiber brush, a sponge or pad of stainless steel wool. The stainless steel wool will leave permanent marks on smooth stainless steel surfaces.

Many uses for stainless steel involve cleaning or sterilizing on a regular basis. Equipment is cleaned with specially formulated caustic or acid solutions, such as phosphoric or sulfamic acids, or organic solvents. Strongly reducing acids such as hydrofluoric or hydrochloric may be harmful to these stainless steels.

Cleaning solutions need to be drained and stainless steel surfaces rinsed thoroughly with fresh water.

Design can aid cleanability. Rounded corners, fillets and absence of crevices on stainless steel equipment facilitates cleaning as do smooth ground welds and polished surfaces.

## SURFACE FINISHES

A range of stainless steel mill surface finishes is available. These are designated by a series of numbers:

**Number 1 Finish** – is hot rolled, annealed and descaled. It is available for plate and sheet and is used for functional applications where a smooth decorative finish is not important.

**Number 2D Finish** – is a dull finish produced by cold rolling, annealing and descaling. This finish is favorable for the retention of lubricants during drawing or other forming operations and is preferred for deep drawn and formed parts.

**Number 2B Finish** – is a brighter finish than 2D. It is produced much like the 2D finish except that a light temper pass is applied after final annealing on a cold mill with polished rolls. This is a general purpose finish used for all but severe cold forming. Because it is smoother as produced, it is more readily polished than the 1 or 2D finishes.

**Number 2BA Finish** – is a very smooth finish produced by cold rolling and bright annealing. A light cold mill pass using highly polished rolls produces a glossy finish. A 2BA finish may be used for lightly formed applications where a glossy finish is desired in the as-formed part.

*Data are typical and should not be construed as maximum or minimum values for specification or for final design. Data on any particular piece of material may vary from those shown herein.*



UES Promura | +61 3 9547 5833 | sales@uespromura.com.au
10-12 McWilliam Street, Springvale VIC 3171 | uespromura.com.au
Distributor reference copy. Technical / issuer particulars retained; contact links localised.

**Polished Finishes** – a variety of ground finishes is available.

Because special equipment or processes are employed in developing these surface finishes, not all are available in the range of products produced by Allegheny Ludlum. Surface requirements should be discussed with Allegheny Ludlum mill representatives.

## SPECIFICATION COVERAGE

Because of the extensive use of Types 316, 316L, 317 and 317L austenitic stainless steels and their broad specification coverage, the following list of specifications is representative, but not complete.

| Product Form | Specification | |
|---|---|---|
| | ASTM | ASME |
| Plate, Sheet and Strip | A 240 | SA-240 |
| Seamless and/or Welded Tubing | A 249/A 249M (316, 316L, 317 only). A 554 | SA-249/SA-249M (316, 316L, 317 only) |
| Seamless and/or Welded Pipe | A 312/A 312M, A 409/A 409M (316, 316L, 317 only) | SA-312/SA-312M, SA-409/SA-409M (316, 316L, 317 only) |
| Bar, Wire | A 276 (316, 316L, 317 only). A478, (316, 316L, 317 only). A479/A 479M, (316, 316L, 317 only). | SA-479/SA-479M (316, 316L, 317 only) |
| Billet, Forgings | A 314 (316, 316L, 317 only). A473 (316, 316L, 317 only). | |
| Flanges, Fittings | A 182/A 182M, A 403/A 403M | SA-182/SA-182M, SA-403/SA-403M |

Types 316, 316L, 317 and 317L stainless steel product forms are assigned allowable stresses in Section II, Part D of the ASME Boiler and Pressure Vessel Code. For the Types 316 and 317 alloys, the maximum use temperature is 1500°F (816°C), whereas for Types 316L and 317L alloys the limit is 850°F (454°C) for Section VIII, Division 1 applications.

All of the grades are accepted for use in food preparation and storage by the National Sanitation Foundation and for contact with dairy products by the Dairy and Food Industries Supply Association-Sanitary Standards Committee. Types 316 and 316L, in particular, are standard materials used in each industry. These also find many uses in the brewery and other beverage industries, pharmaceutical and bioprocessing industries.

*Data are typical and should not be construed as maximum or minimum values for specification or for final design. Data on any particular piece of material may vary from those shown herein.*



UES Promura | +61 3 9547 5833 | sales@uespromura.com.au
10-12 McWilliam Street, Springvale VIC 3171 | uespromura.com.au
Distributor reference copy. Technical / issuer particulars retained; contact links localised.



## Dedicated to Quality Specialty Steel®

® Registered Trademark of ATI Properties, Inc.


© Copyright, Allegheny Ludlum Corporation 1999


UES Promura | +61 3 9547 5833 | sales@uespromura.com.au
10-12 McWilliam Street, Springvale VIC 3171 | uespromura.com.au
Distributor reference copy. Technical / issuer particulars retained; contact links localised.