Selectarc Inox 347

Stainless Steel Electrode
Niobium - stabilised

Classification

AWS A5.4 : E347-17 EN 1600 : E 19 9 Nb R 3 2
ISO 3581-A : E 19 9 Nb R 3 2

Description & Applications

Rutile-basic coated electrode 18%Cr-8%Ni type stainless steel Niobium / columbium stabilised, suited to weld Ti or Nb stabilised stainless steels. The weld metal contains about 8% delta ferrite. Soft fusion without spatters, easy striking and restriking- very easy slag removal. The weld deposit is resistant to intercrystalline corrosion for service temperatures up to 400°C.

Base materials

Stainless steels for general use:

UNS	Alloy	EN 10088	Material N°	UGINE
S30400	304	X5CrNi18-10	1.4301	UGINOX 18-9 B , D, E
S30403	304L	X2CrNi19-11	1.4306	UGINOX 18-10 L
S32100	321	X6CrNiTi18-10	1.4541	UGINOX 18-10 T
S34700	347	X6CrNiNb18-10	1.4550	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Nb	Fe
0.03	0.8	0.7	19.0	9.5	0.3	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>350	>550	>30	+20°C >60

Welding Current & Instructions

Electrode	ØxL (mm)	2,0x300	2,5x300	3,2x350	4,0x350	5,0x450
Current	(A)	45	70	100	135	180

Redrying: 1h at 250°C. Interpass temperature : < 20 0°C.

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= +	~ 70V