INOX R347

Electrodes MMA [SMAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 3581-A : E 19 9 Nb R 12 DIN 8556 : E 199Nb R 12 AWS A-5.4 : E 347-17 W.Nr. : 1.4551		Power generation industry Constructions & Engineering Metallurgy (Steelworks) Petrochemical and chemical industry

- Rutile Nb stabilized electrode for welding Ti or Nb stabilized steels, non-stabilized steels, steels with austenitic structure.
- The deposit is resistant to intergranular corrosion up to 400°C, oxidation up to 800°C, and is also very resistant to cracking at high temperatures.
- Recommended for the petrochemical industry.

Application

Nitric acid processing components, acetic acid production, food, dairy, petroleum, expansion joints, exhaust manifolds, chemical industry, flanges, valves, valve systems.

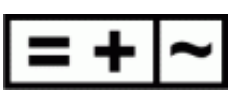
Base material

AISI/ASTM	DIN	W.Nr.
304	X5CrNi1810	1.4301
321	X6CrNiTi1810	1.4541
347	X6CrNiNb1810	1.4550
	G-X6CrNi189	1.4308
	G-X5CrNiNb189	1.4552
A157	G-X10CrNi188	1.4312
347	X5 CrNiNb18 9	1.4543

Typical chemical composition %

C	Si	Mn	Cr	Ni	Nb
<0,04	<1,00	0,70	19,00	10,00	>8x%C

Typical mechanical properties

Yield strength Re [N/mm2]	>350
Tensile strength Rm [N/mm2]	>550
Elongation A5 [%]	>25
Impact energy Kv [J]	>47J (20°C) / >32 J (-60°C) /
Coating type	rutile
Ferrite content	FN = app. 6
Welding current	
Welding positions	

Redrying	300 - 350°C / 2 h
Additional description	Austenitic microstructure with lowcarbon ferrite content at the level of 4-12 FN. Interpass temperature about 150°C

Welding parameters and packing

ø	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
2,0	300 /	30-50	1,5	9,0	
2,5	300 /	50-85	1,4	8,4	55
3,2	350 /	70-125	1,5	9,0	27
4,0	350 /	110-165	1,5	9,0	18
5,0	350 /	165-230	1,5	9,0	12

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