

***selectarc***

## Inox 20/10Nb

**Stainless Steel Electrode  
Niobium - stabilised**

  
**FSH WELDING GROUP**  
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### Classification

AWS A5.4 : E347-16

ISO 3581-A :

E 19 9 Nb R 32

### Description & Applications

Rutile-basic coated electrode, Niobium stabilized 18%Cr-8%Ni type stainless steel, suited to weld Ti or Nb stabilized stainless steels. The weld metal contains about 8 FN delta ferrite. The electrode shows a soft fusion without spatters, easy striking and restriking characteristics, 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	Mo	Cu	Fe
0.03	0.8	0.7	19.0	9.5	0.3	0.1	0.1	base

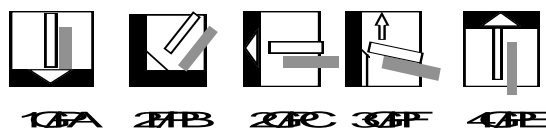
### All Weld Metal Mechanical Properties

$R_{p0.2}$ ( 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 : < 200°C



= + ~ 70V

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