



Selectarc Inox 347B

*Stainless Steel Electrode
Niobium - stabilised*

Classification

AWS A5.4 : E347-15

ISO 3581-A : E 19 9 Nb B 4 2

Description & Applications

Basic coated Niobium / Columbium stabilized 18% Cr – 8% Ni type stainless steel electrode with low Carbon, suited to weld Ti or Nb stabilised stainless steels used for high temperature service. The weld metal contains about 8% delta ferrite. Stable arc, good slag removal, regular weld beads. The weld deposit is resistant to inter-crystalline 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	Mo	Cu	Nb	P	S
0.05	0.7	0.8	19.2	9.6	0.1	0.1	0.4	0.020	0.015

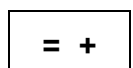
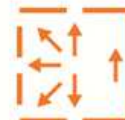
All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
460	610	35	+20°C 100

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350	5,0x450
Current	(A)	75	100	135	170

Redrying: 1h at 250°C. Interpass temperature : <150°C.



FT En-160-190327

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