Selectarc Inox 347H

Stainless Steel Electrode
Niobium - stabilised

Classification

AWS A5.4 : E 347H-16 (E347-16)
ISO 3581-A : E 19 9 Nb R 3 2

Description & Applications

Rutile coated Niobium / Columbium stabilized 18% Cr – 8% Ni type stainless steel electrode with increased Carbon, suited to weld Ti or Nb stabilised stainless steels used for high temperature service. The weld metal contains about 5% delta ferrite. Stable arc, good slag removal, regular weld beads.

Base materials

Stainless steel for general use:

UNS	Aciers	EN 10088	N° de Mat.
S30409	304H	X6CrNi18-10	1.4948
S32109	321H	X8CrNiTi18-10	1.4878
S34709	347H	X7CrNiNb18-10	1.4912

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	Nb	P	S	Fe
0.05	0.7	0.8	19.0	10.0	0.1	0.1	0.5	0.020	0.015	Base

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>485	>620	>35	+ 20°C >55

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350	5,0x450
Current	(A)	75	100	135	180

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

Ind. 15/01

52E-1409

= +	~ 70V