



# Selectarc Inox 347HB

*Stainless Steel Electrode  
Niobium - stabilised*

## Classification

AWS A5.4 : E347-15 (E347H-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 increased Carbon, suited to weld Ti or Nb stabilised stainless steels used for high temperature service (> 400°C). The weld metal contains about 5% delta ferrite. Stable arc, good slag removal, regular weld beads.

### Base materials

#### Stainless steels for general use:

UNS	Alloy	EN 10088	Material N°
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
0.05	0.4	1.3	19.5	10.3	0.1	0.1	0.6	0.020	0.015

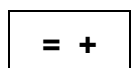
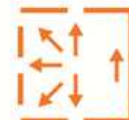
## All Weld Metal Mechanical Properties

R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
440	610	35	+20°C 90

## 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-xxx-190528

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