Selectarc Inox 347

Stainless Steel Electrode
Niobium - stabilised

Classification

AWS A5.4 : E347-17 EN 1600 : E 19 9 Nb R 3 2
ISO 3581-A : E 19 9 Nb R 3 2

Description & Applications

Rutile-basic coated electrode 18%Cr-8%Ni type stainless steel Niobium / columbium stabilised, suited to weld Ti or Nb stabilised stainless steels. The weld metal contains about 8% delta ferrite. Soft fusion without spatters, easy striking and restriking- 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	Fe
0.03	0.8	0.7	19.0	9.5	0.3	Rem.

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.

ind.12



= +	~ 70V

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.