Selectarc Inox 347 AC/DC+

STAINLESS STEEL

DESCRIPTION

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. Good moisture resistance.

CLASSIFICATION

AWS A5.4 : E347-16 EN 1600 : E 19 9 Nb R 32 ISO 3581-A : E 19 9 Nb R 32

BASE MATERIALS 304, 304L, 321, 347

PROCEDURE

Re-drying: 1h at 250°C. Interpass temperature: < 200°C.

MECHANICAL PROPERTIES

Tensile strength:	> 79 770 psi (> 550 MPa)
Yield strength:	> 58 015 psi (> 350 MPa)
Elongation:	> 30 %
Impact (Charpy V):	> 60 J at +20ºC

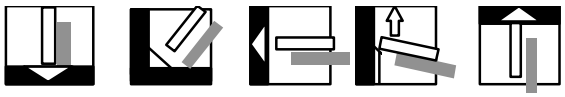
TYPICAL WELD METAL COMPOSITION (%)

C	Mn	Si	Ni	Cr	Nb
<0.03	0.70	0.80	9.5	19.5	0.3

WELDING PARAMETERS

Diameter:	4.0 mm (5/32”)	3.2 mm (1/8”)	2.5 mm (3/32”)
Amperage:	125-145 A	90-110 A	60-80 A

WELDING POSITIONS



1G/PA 2F/PB 2G/PC 3G/PF 4G/PE

Rev.: 15_03

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