

ROWELD-347

LOW CARBON, 19CR-10NI-NB STAINLESS STEEL
ELECTRODE

BASIC ALLOY: CR, NI , NB
AWS/SFA-5.4: E347-16
EN ISO: 3851-A E 19 9 NB B 2 2

KEY FEATURES:

An electrode made of 19Cr-10Ni-Cb, which has a low carbon content and deposits stable weld metal. Excellent protection against intergranular corrosion is provided by weld metal. The electrode produces a smooth arc, facilitates slag detachability, and nearly produces no spatter with a fine finish weld deposit.

APPLICATIONS

- Process Piping
- Power generation equipment
- Petrochemical
- Chemical and pharmaceutical industries

RE-DRY CONDITION:

- Re-Dry the electrode at 300°C for one hour before use.

CHEMICAL COMPOSITION:

C	Mn	Si	S	P	Cr	Ni	Cb
0.08 max.	0.50-2.50	1.00 Max	0.030 Max	0.040 Max	18.00-21.00	9.00-11.00	8xC min - 1.00 max

MECHANICAL PROPERTIES:

UTS (N/mm)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT @	FERRITE (FN)
550-660	30-42	+20C : 60-80 J	4-10

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC+ / AC) Amps	Kg/pkt.	Kg/Case
2.00	5 / 64"	40-60	1.5	7.5
2.50 / 2.40	3 / 32"	60-90	2	10
3.15 / 3.20	1 / 8"	80-110	2	10
4.00	5 / 32"	110-150	2	10
5.00	3 / 16"	150-180	2	10

Royale Weldwell also offers in 15 and 17 Version of same grade electrodes