BETANOX 347 PLUS

STAINLESS STEEL (Austenitic Steel)

AWS A/SFA 5.4 E347-17

CLASSIFICATION:

ISO 3581-A
E 19 9 Nb R 13

IS 5206
E 19.9 Nb R36

KEY FEATURES:

- Acid-Rutile based coating
- 19/10/Nb stabilized weld deposit
- Resistance to cracking
- Less susceptible to embrittlement
- Resistant to scaling upto 850°C
- Excellent resistance to intergranular corrosion due to Nb addition
- Easy slag removal
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding stabilized Cr-Ni steels such as AISI 321, 321H, 347, 347H
- Fabrication of equipments in refineries, power plants, centrifugal pump impellers and shafts, valve faces, seats
- Fabrication of boiler and gas turbine
- Welding of stainless steel tanks, valves, pipes in food, chemical and petrochemical industries
- Suitable for material no. 1.4300, 1.4301, 1.4306, 1.4308, 1.4310, 1.4541, 1.4543, 1.4550, 1.4552, 1.4878, 1.6905

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	Nb
0.05	1.2	0.7	18.9	9.3	0.5

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	615	34	8
Specification		520 min	30 min	3-9

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A
2.5 x 350	50-75
3.15 x 350	80-100
4.0 x 350	110-140

AC (70 OCV) /DCEP

Flat butt and fillet welds only

REDRYING CONDITION:
250-300°C for minimum 1 hr.

Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kg each.

EQUIVALENT:

GMAW	GTAW	FCAW	SAW	
			Flux	Wire
Miginox 347	Tiginox 347	Miginox FC 347	Automelt S33	Subinox 347