

Coated Electrode for Stainless Steels

Classification

EN 1600 : E 19 9 Nb R 12
 AWS A5.4 : (E347-16)
 Werkstoff-Nr : 1.4551

General Description

AS P-347 is a low carbon rutile coated electrode. It gives a niobium stabilized, Cr-Ni type filler metal of AISI 304 or similar quality. It has an excellent strength especially in oxidizing environments like nitric acid. Smooth weld beads are highly resistant to acids and to intergranular corrosion at operating temperatures up to 350°C.

Chemical Composition (w%), Typical, All Weld Metal

C	Si	Mn	Cr	Ni	Nb
0.03	0.90	0.70	19	9.5	0.50

Mechanical Properties, Typical, All Weld Metal

Yield Strength : 520 N/mm²
 Tensile Strength : 600 N/mm²
 Elongation (L=5d) : 35 %
 Impact (ISO-V) : 55 J (+20°C)

Approvals

GOST, SEPRO, TSE

Applications and Materials to be Welded

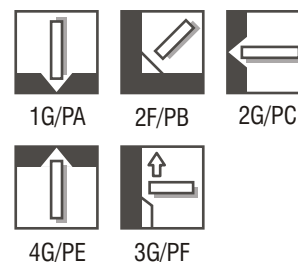
AS P-347 can be used particularly in the welding of austenitic stainless steels of AISI 321 and 347 type. It can also be used for Cr-Ni steels and for steel cast parts having same or similar analysis results with the electrode. Tanks and vessels that are used in chemical and food industries; parts exposing to the effects of acid, gas and vapor; and water fittings are among some application areas. AS P-308 L can be used for 18 % Cr - 8 % Ni, Nb stabilized steel parts that are working under low operating temperatures.

	EN 10088-1/-2	EN 10213-4	W. Nr.
Stabilized Stainless Steels (Nb/Ti)	X6 CrNiTi 18 10	–	1.4541
	X6 CrNiNb 18 10	–	1.4550
	X8 CrNiTi 18 10	–	1.4878
	–	G-X5 CrNiNb 19 10	1.4552
Non Stabilized Stainless Steels	X2 CrNi 19 11	–	1.4306
	X2 CrNiN 18 10	–	1.4311
	X4 CrNi 18 10	–	1.4301
	–	G-X5 CrNi 19 10	1.4308

Welding Parameters / Packing and Diameter Informations / Welding Positions

Current Type and Polarity : AC min 50 V ; DC (+)

Diameter [mm]	Length [mm]	Current [A]	Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]	Export Box Box Weight [kg]
2.50	250	50 - 80	1620	1.5 / 95	1.5
3.25	300	75 - 115	3110	1.9 / 60	2.0
4.00	350	110 - 150	5730	2.6 / 45	2.5
5.00	350	130 - 160	8330	2.5 / 30	2.5



Liability : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance. **Fumes** : Consult information on Welding Safety Sheet, available upon request.