

Classification

EN ISO 3581-A	AWS A5.4 / SFA-5.4
E 19 9 Nb R 3 2	E347-17

Characteristics and typical fields of application

Rutile coated core wire alloyed, stabilised austenitic electrode, mainly for Ti or Nb stabilised 1.4541 / 321 / 347 CrNi-steel grades.

Designed for first class weld seems and easy handling on AC or DC. High current carrying capacity, minimum spatter formation, self-releasing slag, smooth and clean weld profile, safety against formation of porosity due to moisture resistant coating. The fully alloyed core wire ensures the most reliable corrosion resistance.

Resistant to intergranular corrosion up to +400 °C.

Base materials

1.4550 X6CrNiNb18-10, 1.4541 X6CrNiTi18-10, 1.4552 GX5CrNiNb19-11, 1.4301 X5CrNi18-10, 1.4312 GX10CrNi18-8, 1.4546 X5CrNiNb18-10, 1.4311 X2CrNi18-10, 1.4306 X2CrNi19-11
AISI 347, 321,302, 304, 304L, 304LN, ASTM A296 Gr. CF 8 C, A157 Gr. C9, A320 Gr. B8C or D

Typical analysis of all-weld metal

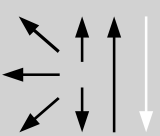
	C	Si	Mn	Cr	Ni	Nb
wt.-%	0.03	0.80	0.80	19.50	10.00	+

Mechanical properties of all-weld metal – typical values (min. values)

Condition	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J	
	MPa	MPa	%	+20 °C	-120 °C
u	450 (≥ 350)	620 (≥ 550)	35 (≥ 25)	70	≥32

u untreated, as welded

Operating data

	Polarity: DC (+) AC	Redrying if necessary: 120 – 200 °C, min. 2h	Electrode identification: FOX SAS 2-A 347-17 E 19 9 Nb R	ø mm	L mm	Amps A
				1.5	250	25 – 40
	2.0	300	40 – 60			
	2.5	250/300/350	50 – 90			
	3.2	300/350	80 – 120			
	4.0	350	110 – 160			
	5.0	450	140 – 200			

Approvals

TÜV (01105.), DB (30.014.06), ABS, DNV GL, VUZ, CE, NAKS (Ø 2,5; Ø 3,2; Ø 4,0)