GWELD
SEAL OF TRUST

GRIBINOX 347

IDENTIFICATION
GRIBINOX 347 E347 -15

CLASSIFICATION
AWS/SFA 5.4: E347-15 ; IS: 5206: E 19.9 Nb B 20

DESCRIPTION
A basic coated stabilized stainless steel electrode with a controlled composition and controlled ferrite content, designed for welding austenitic stainless steel such as AISI grades 347, 321, 301, 302, 304 or equivalent. The electrode has excellent arc stability and low spatter loss. The electrode can be manipulated easily in all welding positions. The deposited welds are of radiographic quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Nb
0.08 max	0.70 - 2.50	0.90 max	0.025 max	0.03 max	18.0 - 21.0	9.0 - 11.0	8 x %C min or 0.8% max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
560 - 660	30 - 40	27°C	50 - 90

TYPICAL APPLICATIONS
- For welding stainless steels type 321, 347, 304.
- Also for surfacing unalloyed, low alloy and cast steels, Food Stuffs, Dairy, Textile, Chemical & Aircraft

Industries, Household appliances, pipe-line figgings, Hospital Apparatus, etc.

WELDING PROCEDURE
- The base metal should be free from oil, Grease or Dirt before welding.
- Keep a short arc-length.
- The weld bead should be cleaned with stainless steel brush.
- Maintain interpass temperature 150°C max.
- Redry electrodes if required at 200°C for one hour.

REDRYING : 250°C / 2 hrs
ASME SECTION IX QUALIFICATION : QW-432 F-NUMBER,5, QW-442 A-NUMBER, 8

WELDING POSITION :

PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 100	2 x 5 = 10	94 x 5 = 470
3.15 / 3.20	350	90 - 120	2 x 5 = 10	60 x 5 = 300
4	350	130 - 170	2 x 5 = 10	38 x 5 = 190
5	350	170 - 240	2 x 5 = 10	24 x 5 = 120