GWELD
SEAL OF TRUST

GRINOX 47

IDENTIFICATION
GRINOX 47 : E 347-16

CLASSIFICATION
AWS/SFA 5.4: E347-16 IS: E 19.9 Nb R 26

DESCRIPTION
An extruded, rutile based heavy coated electrode for welding 18/8 Chromium Nickel Stabilised stainless steel type AiSi/ASTM 321 or 347 grade. Weldable in all positions. Arc striking and re-striking properties are excellent. Arc is soft & stable. The spatter is very low and the slag is easy to remove. The weld deposit is free from cracks and porosity. The weld bead is finely - rippled, smooth and regular. Due to stabilisation with Columbium, the weld deposit has increased resistance against intergranular Corrosion.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Cb
0.08 max	0.70 - 2.50	0.90 max	0.025 max	0.03 max	18.0 - 21.0	9.0 - 11.0	8X % C min or 1 % max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
540 - 640	30 - 40	27°C	70 - 120

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.

WELDING POSITION :

PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS AC / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)

2.5	350	55 - 75	2 x 5 = 10	94 x 5 = 470
3.15 / 3.20	350	85 - 110	2 x 5 = 10	60 x 5 = 300
4	350	110 - 140	2 x 5 = 10	38 x 5 = 190
5	350	140 - 180	2 x 5 = 10	24 x 5 = 120