

GRITINOX 347

IDENTIFICATION

GRITINOX 347 E347-17

CLASSIFICATION

AWS/SFA 5.4 E347-17 BS 2926 E19.9.NbR

DIN 8556 E199NbR26

DESCRIPTION

A rutile flux coated AC/DC electrode designed for welding of stabilised stainless steel grades 347 and 321. Operability is excellent with a low spatter arc, producing a smooth weld bead surface and self-releasing slag. The electrode deposits X-ray quality weld metal.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Ni	Nb	Cu	Mo	S	P
0.08 max	0.5 - 2.5	0.35 - 0.90	18 - 21	09-Nov	8 x %C or 1.0 max	0.5 max	0.75 max	0.025 max	0.03 max

MECHANICAL PROPERTIES (RANGE)

TS (N/mm ²)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
		520 - 660	30 - 42

TYPICAL APPLICATIONS

- For welding ASTM/ASME 321, 347, DIN 1.4541, 1.4543, 1.4546, food brewery and chemical process vessels, pipelines and nuclear engineering.
- Suitable for unstabilised grades 304, 304L etc. Also suitable for welding petrochemical, power and pharmaceutical industries, paper processing plant.

CORROSION RESISTANCE : Good resistance to general and intergranular corrosion, particularly at elevated temperatures.

MICROSTRUCTURE : Austenite with 5 to 11 FN (5 - 10% Ferrite) Typical 7 FN.

ASME IX QUALIFICATION : QW-432 F-NUMBER 5, QW-442 A-NUMBER 8

REDRYING: 300°C / 2 hrs, max 5 cycles, 10 hr. total

WELDING POSITION :



PACKING PARAMETERS

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

2.5	350	50 - 75	2 x 5 = 10	94 x 5 = 470
3.15 / 3.20	350	80 - 120	2 x 5 = 10	60 x 5 = 300
4	350	100 - 160	2 x 5 = 10	38 x 5 = 190
5	350	130 - 210	2 x 5 = 10	24 x 5 = 120