



BETANOX 347 PLUS

CLASSIFICATIONS

AWS A/SFA 5.4 E 347-17
IS 5206 E 19.9 Nb R26

COATING TYPE: Acid-Rutile
COATING FACTOR: Medium

IDENTIFICATION: Brand Printed

CURRENT CONDITIONS: AC, DC (+)

5.0	4.0	3.2	2.5	2.0
150-	110-	80-	50-	35-
180	140	100	75	45

CHARACTERISTICS

A 19/10Nb stabilized SS electrode with controlled Ferrite content of 6 to 9% for maximum resistance to cracking. Nb prevents Carbide precipitation in the temperature range of 425-823°C. The weld metal has excellent creep strength and is of radiographic quality. Excellent arc stability and low spatter loss. All sizes strike and re-strike easily. The slag is easily controlled and does not interfere with the arc action. Weld beads are smooth, uniform and of excellent appearance.

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

300°C for 2 hours

(Optionally also available in vacuum-packed condition, redrying not required in this packaging)

TYPICAL APPLICATIONS

For the welding of 18/8Nb stabilized SS, represented by AISI types 321, 347. Fabrication of equipments in Refineries, Chemical industries, Power Plants, Centrifugal pump impellers and shafts, valve faces, seats.

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	% Elong. (L=4Xd)	RA %	Ferrite No.
AW	550-690	30-40	50 Min.	6-9

AW : As-welded

WELD METAL CHEMISTRY, wt%

C - 0.08 max.	S - 0.03 max.	Cr - 18.0-21.0
Mn - 1.00-2.0	P - 0.04 max.	Nb - 1.0 max.
Si - 0.90 max.	Ni - 9.0-11.0	

PACKING DATA

	4.0	3.2	2.5	2.0
Dia., mm	4.0	3.2	2.5	2.0
Length, mm	300	300	300	300
Wt. per carton, kgs	6	6	6	6
Cartons/ box	3	3	3	3
Wt. per box, kgs	18	18	18	18

Related Products: TIGINOX 347, MIGINOX 347, Automelt 347 wire + Automelt S76 flux