



## BETANOX 347 PLUS

STAINLESS STEEL (Austenitic Steel)



19/10/Nb stabilized type stainless steel Electrode

**CLASSIFICATION : ISO 3581-A**

**AWS A/SFA 5.4**

**IS 5206**

E 19 9 Nb R 13

E 347-17

E 19.9 Nb R36

### KEY FEATURES :

- Acid-Rutile based coating
- 19/10/Nb stabilized weld deposit
- Resistance to cracking
- Less susceptible to embrittlement
- Resistant to scaling upto 850°C
- Excellent resistance to intergranular corrosion due to Nb addition
- Easy slag removal
- Radiographic quality weld

### WELDING POSITION :



**AC (70 OCV) /DCEP**

### TYPICAL APPLICATIONS :

- Welding stabilized Cr-Ni steels such as AISI 321, 321H, 347, 347H
- Fabrication of equipments in refineries, power plants, centrifugal pump impellers and shafts, valve faces, seats
- Fabrication of boiler and gas turbine
- Welding of stainless steel tanks, valves, pipes in food, chemical and petrochemical industries
- Suitable for material no. 1.4300, 1.4301, 1.4306, 1.4308, 1.4310, 1.4541, 1.4543, 1.4550, 1.4552, 1.4878, 1.6905

**REDRYING CONDITION : 250-300°C for minimum 1 hr.**

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	<b>C</b>	<b>Cr</b>	<b>Ni</b>	<b>Mo</b>	<b>Mn</b>
	0.05	19.3	9.8	0.2	1.6
Specification	0.08 max	18.0-21.0	9.0-11.0	0.75 max	0.5-2.5
	<b>Si</b>	<b>P</b>	<b>S</b>	<b>Cu</b>	<b>Nb plus Ta</b>
	0.4	0.02	0.02	-	0.5
Specification	1 max	0.04 max	0.03 max	0.75 max	8xC, min to 1.00 max

### MECHANICAL PROPERTIES OF ALL WELD METAL :

	<b>Condition</b>	<b>UTS, MPa</b>	<b>EL%</b>	<b>Ferrite No.</b>
Typical	As Welded	615	34	8
Specification		520	30 min	6-9

### PARAMETERS - PACKING DATA :

<b>Ø x L, mm</b>	<b>Amperage, A</b>	<b>Wt./Carton, Kg</b>	<b>Cartons/Box</b>	<b>Net wt./Box, Kg</b>
2.0 x 300	50-75	2	5	10
2.5 x 350	80-100	2	5	10
3.15 x 350	110-140	2	5	10
4.0 x 350	150-180	2	5	10

**EQUIVALENT : GMAW wire: Miginox 347**

**GTAW filler: Tiginox 347**