

ES 347-17

Type Acid-rutile

SMAW
E347-17

ESWECO
The Art of Welding

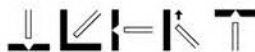
Description

ES 347-17 is a niobium-stabilised, stainless-steel, LMA electrode with low carbon content for welding stainless types 321 and 347. It is resistant to intergranular corrosion up to 400°C.

Typical application: Petrol Chemical Industry, Power Generation Construction, Shipbuilding & Offshore and Food & beverage.

Current

DC+, AC OCV 50 V



Classifications

EN 1600	E 19 9 Nb R 1 2
SFA/AWS A5.4	E347-17
Werkstoff Nr.	1.4551

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Nb	Cu
<0.03	0.7	0.9	20.0	10.0	<0.3	<0.6	<0.3

Typical mech. Properties all weld metal

Yield stress, MPa	480
Tensile strength, MPa	620
Elongation A5, %	40

Charpy V

Test temps, °C	Impact values, J
+20	60
-80	40

Ferrite content FN 6-12

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	300	50-80	27
3.2	350	85-110	27
4.0	350	120-160	28