

RATNA 347

Low carbon, 19Cr-10Ni-Cb stainless steel Electrode.

CLASSIFICATION : AWS/SFA-5.4: E 347-16 , DIN E 199NbR
IS-5206: E 19.9NbR 26, BS 19.9NbR

APPROVAL :

CHARACTERISTICS : A low carbon, 19Cr-10Ni-Cb stainless steel electrode depositing stabilized weld metal. Weld metal offers excellent resistance to intergranular corrosion. Electrode gives smooth arc, easy slag detachability and is almost spatter free with fine finish weld deposit.

APPLICATION :

- 1) Ideally suitable for welding stainless steel conforming to AISI 304, 304L, 321, 347.
- 2) And their equivalents used in fertilizer, petrochemical, chemical and pharmaceutical industries.

RE-DRY CONDITION : Re-Dry the electrode at 250°C for 1 hrs before use.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P	Cr	Ni	Cb
0.08 max.	0.50-2.50	1.00 Max	0.030 Max	0.040 Max	18.00-21.00	9.00-11.00	8xC Min. -1.00 Max

ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm ²)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT	FERRITE (FN)
550-660	30-42	+20 ⁰ C : 60-80 J	4-10

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+/AC) Amps	kg./pkt.	kg./Case
2.50/ 2.40 X 350	3/ 32" X 14"	60-80	2	20
3.15/ 3.20 X 350	1/ 8" X 14"	80-110	2	20
4.00 X 350	5/ 32" X 14"	110-140	2	20
5.00 X 350	3/ 16" X 14"	150-180	2	20

Customer packing on request.