

Cor-A-Rosta® 347

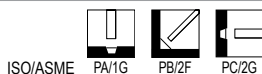
CLASSIFICATION

AWS A5.22 : E347T1-1
 ISO 17663-A : T 19 9 Nb R M 3

GENERAL DESCRIPTION

Rutile gas shielded stainless steel wire electrode for downhand welding
 For Ti or Nb stabilized 304 or equivalent steels
 Excellent resistance in oxidizing environments such as nitric acid
 High resistance to intergranular corrosion
 Easy slag release and smooth bead appearance

WELDING POSITIONS



CURRENT TYPE

DC +
 M21 : Mixed gas Ar+ (>15-25%) CO₂
 Amount : 15-25 l/min

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

Shielding gas	C	Mn	Si	Cr	Ni	FN (acc.WRC 192)
M21 /C1	0.05	1.4	0.6	19.5	10	5

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)
						+20°C
Required: AWS A5.22			not required	min.520	min. 30	
ISO 17663-A			min. 350	min. 550	min. 25	
Typical values	M21	AW	435	600	42	90

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.2
Unit : 15 kg spool S300	X

Cor-A-Rosta® 347 : rev. EN 24

Cor-A-Rosta® 347**MATERIALS TO BE WELDED**

Steel grades	EN 10088-1/-2	EN 10213-4	Mat. Nr	ASTM/AISI A240/A312/A351	UNS
Ti-, Nb stabilized					
	X6 CrNiTi 18 10		1.4541	(TP)321 (TP)321H	S32100 S32109
	X6 CrNiNb 18 10		1.4550	(TP)347 (TP)347H	S34700 S34709
		GX5 CrNiNb 19-10	1.4552	CF-8C	J92710
Non stabilized					
	X4CrNi 18-10		1.4301	302 (TP)304	S30400
	X2CrNi 19-11		1.4306	(TP)304L	S30403
		GX5 CrNi 19-10	1.4308	CF-8	J92600
			1.4312	(TP)304H	S30409

WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions		
	PA/1G	PB/2F	PC/2G
1.2	100-250A	100-250A	100-200A