Stainless steel electrode

Classification

AWS A5.4-92 : E347-15
EN 1600-97 : E 19 9 Nb B 22

Temperature Range

pressure parts: -120...+400°C
oxidation resistance: to 800°C

General description

Basic coated all position stainless steel electrode
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
Strong electrode coating

Welding positions

ISO/ASME PA/1G PB/2F PC/2G PF/3G up PE/4G PF/5G up

Current type

DC electr. +

Approvals

TÜV
+

Chemical composition (w%), typical, all weld metal

C	Mn	Si	Cr	Ni	Nb	FN
0.020	1.6	0.5	20.0	10.0	0.40	6-12

Mechanical properties, all weld metal

	Condition	0.2% Proof strength (N/mm²)	Tensile strength (N/mm²)	Elongation (%)	Impact ISO-V(J) +20°C	-20°C	-120°C
Required: AWS A5.4-92		not required	min. 520	min. 30	not required		
EN 1600-97		min. 350	min. 550	min. 25	not required		
Typical values	AW	500	630	35	80	50	40

Packaging, available sizes and identification

	Diameter (mm)	3.2	4.0	5.0
	Length (mm)	350	350	450
Unit: Box	Pieces / unit (nominal)	150	100	75
	Net weight/unit (kg)	4.8	4.4	6.8

Identification Imprint: 347-15/Jungo 347 Tip colour: brown

Jungo® 347: rev. EN 15

Materials to be welded

Steel grades	EN 10088-1/-2	EN 102 13-4	W.Nr.	ASTM/ACI A240/A312/A351	UNS
Ti-, Nb stabilized	X6 CrNiTi 18-10		1.4541	(TP)321	S32100
				(TP)321H	S32109
	X6 CrNiNb 18-10		1.4550	(TP)347	S34700
				(TP)347H	S34709
		GX5CrNiNb19-10	1.4552	CF-8C	J92710
Non stabilized	X4 CrNi 18-10		1.4301	302	
	X2 CrNi 19-11		1.4306	(TP)304	S30400
		GX5 CrNi 19-10	1.4308	(TP)304L	S30403
			1.4312	CF-8	J92600
				(TP)304H	S30409

Calculation data

Sizes Diam. x length	Current range type	Current	Arc time - per electrode at max. current -	Energy - per electrode at max. current -	Dep.rate - per electrode at max. current -	Weight/ 1000 pcs.	Electrodes/ kg weldmetal	kg Electrodes/ kg weldmetal
(mm)	(A)		(s)*	E(kJ)	H(kg/h)	(kg)	B	1/N
3.2 x 350	80 - 100	DC+	51	135	1.3	32.4	53	1.72
4.0 x 350	100 - 130	DC+	66	206	1.7	44.4	32	1.56
5.0 x 450	130 - 160	DC+	69	378	2.3	90.9	23	1.92

* stub end 35mm

Welding parameters, optimum fill passes

Welding positions Diameter (mm)	PA/1G Current (A)	PB/2F	PC/2G	PF/3G up	PE/4G	PF/5G up
3.2	95	90	90	75	75	75
4.0	125	110	125	100	100	100
5.0	150	150				