

STAINLESS STEEL ELECTRODES**RASI 347 - 16****AUSTENITIC TYPE****CLASSIFICATION :**

AWS : A5.4 E 347-16

IS : 5206 E 19.9Nb

CHARACTERSTICS :

RASI 347-16 is a rutile type Austenitic Stainless Steel type of 19/10 Nb Stabilised Electrode with controlled ferrite content of 6-9% excellent resistant to scaling corrosion and cracking at temperature up to 800°C Niobium prevents harmful carbide precipitation in the temperature range 425°C to 850°C.

The weld bead are smooth, uniform and of excellent appearance and all positions Electrodes.

APPLICATIONS :

Is used for Welding of AISI Steels 347 and 321. Generally on 18/8 Austenitic Stainless steels stabilised with titanium or Niobium. In the manufacturing of gas turbines, Equipments in Soap Industries, Chemical Equipments, Air Craft Industries etc.

CHEMICAL COMPOSITION OF ALL WELD METAL

ELEMENTS	C	Mn	Si	Cr	Ni	Nb	S	P
PERCENTAGE	0.08	2.5	0.9	18-21	8-11	0.65-1.0	0.03	0.04

Note : Single values shown above are maximum

MECHANICAL PROPERTIES OF ALL WELD METAL

UTS (N/mm ²)	Elongation %	Ferrite No.	CVN Impact - 190°C
520 Min	30 Min	6-9	60-90J

WELDING CURRENT & PACKING DATA : AC70V/DC(+)**ELECTRODE SIZE, CURRENT RANGE & PACKING**

Dia (mm)	2.5 x 350	3.15 x 450	4.0 x 450	5.0 x 450
Current (A)	60-90	100-130	140-180	180-250
Pieces/Pkt/Kg	~100/2Kg	~60/2Kg	~45/2Kg	~30/2Kg
Pkts/Box/Kg	8	8	8	8

STORAGE

Re-dry the Electrode at 300°C for 1 Hr, use short arc during welding store the electrode in dry conditions.