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Rutile type stainless steel electrode

STARBLAZE PRIME 347 HF

Classification

AWS A 5.4: E 347-16

DIN EN 1600: E 19 9 Nb R 12

DIN EN ISO 3581-A : E 19 9 Nb R 12

Werkstoff Nr: 1.4550

Description and applications

Rutile-basic-coated austenitic stabilized stainless steel electrode with approx 10-12% ferrite. Coating with very low moisture pick up (LMA-type). Soft fusion, without spatters, very easy slag removal, exceptional weld bead appearance, easy restriking. Electrode for joint welding on unstabilized and stabilized austenitic, chemical resistant CrNi-steels at working temperature upto 400°C, for corrosion resistant Cr-steels and alloyed similar claddings. Packed in vacuum pack system.

Base materials

Stainless steels for general use:				
UNS	**Alloy**	**EN 10088**	**Material N[a]**	**UGINE**
S30400	304	X5CrNi18-10	1.4301	UGINOX 18-9, B D, E
S30403	3O4L	X2CrNi19-11	1.4306	UGINOX 18-10 L
S32100	321	X6CrNiTi18-10	1.4541	UGINOX 18-10 T
S34700	347	X6CrNiNb18-1O	1.4550	

Typical weld metal Chemical Composition (%)

C	Si	Mn	Cr	Ni	S	P	Nb
0.04	0.80	1.00	19.50	9.50	0.015	0.020	0.45

All weld metal mechanical properties (typical)

Tensile Strength R_m(N/mm²)	Elongation A_5 (%)	Charpy Impact value (ISO-V J RT)
590	40	80

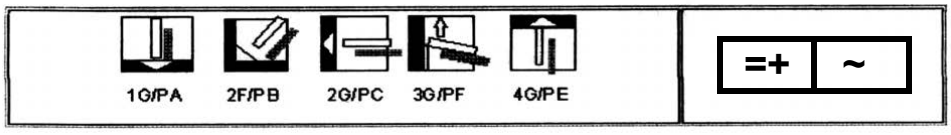
Amperes (A)

2.50mm	3.15mm	4.00mm	5.00mm
50-80	70-110	100-150	140-190

Welding instruction

Keep dry and avoid condensation. Interpass temperature :< 200°C. Re-dry generally not required, if necessary redry electrodes at 300-350°C for 1hr.

Welding Positions



Stellaris Specialities India Ltd.

(Division: StarBlaze India)

GST No.: 06AAICS2482B1ZK / Legal Metrology No.: GOI/DL/2022/4850

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