



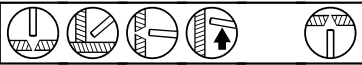
Cromarod 347

SMAW - (Stick) - MMA
Stainless Steel

Date:	2013-10-21
Revision:	23

Description:

Cromarod 347 is a niobium stabilised, rutile flux coated electrode used for welding the Nb or Ti stabilised 18% Cr/ 10% Ni austenitic stainless steel grades 347 and 321. It is also suitable for the unstabilised grades 304 and 304L. Cromarod 347 is primarily intended for use where resistance to intergranular corrosion is required. For welding the controlled carbon material grades 321H and 347H, used for structural applications at temperatures above 400 °C, Cromarod 308H is recommended because of its superior creep strength. The electrode has good positional characteristics and produces low spatter levels and good slag detachability.

Welding positions:**Coating type:**

Rutile

Welding current:

DC+, AC OCV > 39V

Ferrite content:

FN 8 (WRC-92)

Corrosion resistance

Good resistance to general and intergranular corrosion particularly at elevated temperatures.

Scaling temperature:

Approx. 850 °C in air.

Redrying temperature:

350 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,6	0,5			18,0	9,0
Typical	0,03	0,9	0,7	0,020	0,015	20,0	10,0
Max	0,08	1,0	2,0	0,025	0,025	21,0	11,0

	Mo	Cu	V	Nb
Min				10xC
Typical	0,1	<0,1		0,4
Max	0,5	0,5	0,1	1,0

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 350 MPa	480 MPa
Tensile Strength, Rm:	≥ 560 MPa	620 MPa
Elongation, A5	≥ 30%	35%
Impact energy, CV:		-60 °C • 40 J

Classification:

AWS A5.4	E 347-17
ISO 3581-A	E 19 9 Nb R 12

Approvals:

CE

Produkt data:

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off time/ electrode (sec.)
2,5	300	74482500	50-80	21	0,62	90	1,0	34
3,2	350	74483200	80-110	22	0,64	46	1,3	55
4,0	350	74484000	130-170	22	0,63	31	1,9	56
4,0	450	74484045	110-135	22	0,65	23	1,6	92
5,0	450	74485000	160-220	22	0,65	15	2,8	86

