

SB ZULFI E 347-15

Brand Name & Classification

AWS/ASME SFA-5.4:E 347-15
DIN 8556: E 19 9 Nb B 20
EN 1600: E 19 9 Nb B 42

Approvals Grade

Properties

Electrode for welding of stabilized austenitic stainless Cr-Ni steels or cast steels, as well as stainless or heat resisting Cr steels or cast steels. For operating temperatures of up to + 400⁰ c, non scaling up to 800⁰c.

Application

1.4541: X 6 CrNiTi 18 10	1.4301: X 5 CrNi 18 10
1.4550: X 6CrNiNb 18 10	1.4303: X 5 CrNi 18 12
1.4552: G- X 5CrNiNb 18 9	1.4308: G-X 6 CrNi 18 9
	1.4310: X 12 CrNi
17 7	1.4319: X 5 CrNi
17 8	

Weld Metal Analysis Typical values

Carbon: 0.025

Silicon: 0.90

Manganese: 0.80

Chromium: 19.0

Nickel: 10.0

Niobium: 0.40

Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation	Impact Strength
>420 N/MM2	540 - 620 N/mm2	> 33 %	60 J at +20 ⁰ c

Welding Current & Positions



Current

Dia	Length	Amperes
2.5	300	45-80
3.2	350	70-120
4.0	350	100-150