

<b>NSD-347</b>	<b>FOR WELDING STABILISED AUSTENITIC STAINLESSS STEELS CONTAINING A NOMINAL 19 Cr and 10Ni</b>					<b>DATA SHEET NO. 75A</b>					
	SPECIFICATION	AWS A5.4		BS EN 1600		JIS Z 3221					
CLASSIFICATION	E347-15		E 19 9 Nb B		D347-15						
PRODUCT DESCRIPTION	<p>A chemically basic flux with a low level of silicious minerals together with small alloy additions to compensate for arc losses.</p> <p>The flux is concentrically extruded onto a fully alloyed core wire and bound by a blend of silicates that assures both coating strength and resistance to subsequent moisture absorption.</p>										
WELDING FEATURES OF THE ELECTRODE	<p>Suitable for use on DC+ only the arc is very forceful but the nature of the molten slag allows easy vertical up and overhead welding.</p> <p>Ideal for site welding as the extra shielding gas from the basic minerals ensures safety against porosity, even in windy conditions.</p>										
APPLICATIONS AND MATERIALS TO BE WELDED	<p>Applications for the electrode are to be found in the Chemical, Petro-Chemical and Cryogenic Processing and Storage Industries as well as the Food, Brewery and Pharmaceutical Industries using the following materials:</p> <p>ASTM-ASME 321 347 CF8C (cast)          UNS S32100 S34700</p> <p>NSN-347 is designed to weld Nb and Ti Stabilised Austenitic Stainless Steels at service temperatures between 100°C and 400°C.</p>										
WELD METAL ANALYSIS COMPOSITION % BY Wt.	C	Mn	Si	S	P	Cr	Ni	Mo	Nb (+Ta)	Fe	FN
MIN	-	0.5	-	-	-	18	9.0	-	8xC		4
MAX	0.08	2.5	1.0	0.03	0.04	21	11	0.75	1.0		12
TYPICAL	0.04	2.0	0.4	0.01	0.02	19.5	10	0.12	0.8	Bal.	7
WELD METAL PROPERTIES (ALL WELD METAL)	PROPERTY		UNITS	MINIMUM		TYPICAL		OTHERS			
	Tensile strength		N/mm <sup>2</sup>	520		680		HV 215			
	0.2% Proof stress		N/mm <sup>2</sup>	-		540					
	Elongation on 4d		%	30		33					
	Reduction of Area (RA)		%	-		-					
	Impact energy -46°C		J	-		35					
WELDING AMPERAGE AC or DC+	Ø (mm)	2.0	2.6	3.2	4.0	5.0					
	MIN	35	60	80	130	160					
	MAX	80	100	130	170	210					
OTHER DATA	Electrodes that have become damp should be re-dried at 150°C for 1hour.										
RELATED PRODUCTS	Please contact our Technical Department for detail.										