

SUPRANOX 347

Obalená elektróda pre zváranie nehrdzavejúcich a žiaruvzdorných ocelí
Covered electrode for welding stainless and heat resisting steels
Elektroda otulona do spawania stali nierdzewnych i żaroodpornych



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Standards:	DIN EN 1600	E 19 9 Nb R 12
	DIN 8556	E 19 9 Nb R 23
	AWS/ASME SFA-5.4	~E347-16
	Comparable No. of Materials:	1.4551

SK Vlastnosti a použitie:

Obalená elektróda pre zváranie nehrdzavejúcich stabilizovaných austenitických chrom-niklových ocelí, nehrdzavejúcich príp. žiaruvzdorných Cr-ocelí. Pre prevádzkové teploty do +400 °C, žiaruvzdorné do +800 °C.

GB Applications and properties:

Electrode for welding stabilized austenitic stainless Cr-Ni steels or cast steels, as well as a stainless or heat resisting Cr steels or cast steels. For operating temperatures of up to +400 °C, non-scaling up to +800 °C.

POL Zastosowanie i własności:

Elektroda do spawania stabilizowanych austenitycznych stali nierdzewnych Cr-Ni lub staliw, jak również chromowych stali żaroodpornych lub staliw. Maksymalna temperatura robocza stopiwa do +400 °C, odporność na tworzenie zgorzeliny do temperatury +800°C.

Materials for instance:

Joint welding of alloy steels			
No. of Materials	EN-Designation	No. of Materials	EN-Designation
1.4541	X6CrNiTi18-10	1.4550	X6CrNiNb18-10

Approvals: TÜV, DB

Weld metal analysis (typical values in %):

C	Si	Mn	Cr	Ni	Mo	P	S
0,025	0,90	0,80	19,00	10,00	0,40	≤0,025	≤0,020

Mechanical properties of all-weld metal (single values are typical values):

Heat treatment	0,2 % Proof stress [N/mm ²]	Tensile strength [N/mm ²]	Elongation A ₅ [%]	Impact energy ISO-V [J]
				+20 °C
AW	≥420	≥600	≥25	≥50

AW = as-welded

Redrying: Generally not required. We recommend redrying 2 hrs. at 300 - 350 °C

Amperage [A]:

Ø 2,0	Ø 2,5	Ø 3,2	Ø 4,0
35–60	45–80	70–120	100–150

Number of pieces, net weights:

Ø [mm]	Length [mm]	Pieces/Package	Weight/Package [kgs]	Pieces/Carton	Weight/Carton [kgs]
2,0	300	135	1,5	810	8,8
2,5	300	85	1,5	510	9,1
3,2	350	115	4,1	345	12,3
4,0	350	70	3,8	210	11,4

Type of current/Polarity/Welding positions:

