Cor-A-Rosta 347

Stainless rutile cored wire

Classification

AWS A5.22 : E347T0-4
ISO 17663 : T 19 9 Nb R M 3

General description

Rutile gas shielded stainless steel wire electrode for downhand welding
For Ti or Nb stabilized 304 or equivalent steels
Excellent resistance in oxidizing environments such as nitric acid
High resistance to intergranular corrosion
Easy slag release and smooth bead appearance

Welding positions

ISO/ASME PA/1G PB/2F PC/2G

Current type/Shielding gas

DC +
Ar+ (>5-25%) CO_2 (EN 439: M21)
15-25 l/min

Chemical composition (w%) and Ferrite Number (FN). typical. all weld metal

Shielding gas	C	Mn	Si	Cr	Ni	Nb	FN
M21	0.03	1.2	0.45	19.0	10.5	0.5	8

Mechanical properties, typical, all weld metal

		Shielding gas	Condition	Yield strength (N/mm^2)	Tensile strength (N/mm^2)	Elongation (%)	Impact ISO-V(J) +20°C
Required:	AWS A5.22			not required	min. 520	min. 30	
	ISO 17663			min. 350	min. 550	min. 25	
Typical values		M21	AW	440	610	41	85

Packaging and available sizes

Unit	Net weight (kg)	Diameter (mm) 1.2
Plastic spool S300	15	X

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Materials to be welded

Steel grades	EN 10088-1/-2	EN 10213-4	W.Nr.	ASTM/ACI A240/A312/A351	UNS
Ti-, Nb-stabilized	X6 CrNiTi 18 10		1.4541	(TP)321	S32100
				(TP)321H	S32109
	X6 CrNiNb 18 10		1.4550	(TP)347	S34700
				(TP)347H	S34709
		GX5 CrNiNb 19-10	1.4552	CF-8C	J92710
Non stabilized				302	
	X4CrNi 18-10		1.4301	(TP)304	S30400
	X2CrNi 19-11		1.4306	(TP)304L	S30403
		GX5 CrNi 19-10	1.4308	CF-8	J92600
			1.4312		
				(TP)304H	S30409

Welding parameters, optimum fill passes in shielding gas M21

Welding position	PA/1G	PB/2F	PC/2G
Diameter (mm)	Current (A)		
1.2	100-250	100-250	100-200