

ROCKWELD 347

Rockweld 347 is a rutile type electrode for welding chromium-nickel steels of the niobium or titanium stabilised 18Cr/8Ni type. Low spatter loss. Stable arc. Regular bead appearance. Easy slag removal.



CLASSIFICATIONS

AWS	A5.4	E347-16
BS	2926	19.9.Nb.R.
DIN	8556	E 19 9 Nb R 26

CHEMICAL ANALYSIS

% Carbon	<0.03	% Chromium	19.00
% Manganese	0.700	% Nickel	10.00
% Silicon	0.700	% Niobium	0.600

**TYPICAL MECHANICAL PROPERTIES
ALL WELD METAL**

Tensile Strength	540 - 640 MPa
Yield Strength	>390 MPa
Elongation on 5d	>30%
Impact Strength ISO-V 20°C	>65J

PACKING DATA

Diameter (mm)	Current (A)	Item Number	Pack Mass (Kg)
2.50	45-80	078-074	3 x 5
3.20	70-120	078-076	3 x 5
4.00	100-150	078-078	3 x 5
5.00	130-200	078-080	3 x 5

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