


Technical data sheet <small>100122MBA</small>	Coated SMAW Electrode WA TETRA B 347L-E	
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CLASSIFICATION

ASME IIC SFA 5.4 / AWS A 5.4:	E347-15
EN ISO 3581-A:	E 19 9 Nb B 42
ASME IX Qualification	QW432 F-N° 5 QW442 A-N° 8

DESCRIPTION AND APPLICATIONS

- Basic coated stainless steel SMAW electrode
- 19% Cr - 9% Ni- niobium stabilized type
- Easy slag release and smooth bead appearance

APPLICATIONS

WA TETRA B 347L-E is suitable for welding stabilised stainless steels containing 16 to 21% Cr and 8 to 13% Ni as well as for cladding / weld overlay.

Examples:

AISI	UNS	Material number	EN Symbol
321	S32100	1.4541	X6 CrNiTi 18-10
347	S34700	1.4550	X6 CrNiNb 18-10

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Cr	Ni	Nb	Fe
0.03	1.2	0.3	19.2	9.6	0.4	Bal

Typical ferrite level: 6 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2[MPa]	A ₅ [%]	CVN [J]
550	350	30	+20°C :47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2[MPa]	A ₅ [%]	CVN [J]
610	460	35	+20°C :100

OPERATING CONDITIONS

Electrode ØxL [mm]	2,5x350	3,2x350	4,0x350
Current [A]	70	100	130
= +	~ 70V		

Re-drying: if necessary 1h at 250°C.

WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PF, PE
ASME IX: 1G, 2F, 2G, 3G, 4G

PACKAGING

Electrode ØxL [mm]	2,5x300	3,2x350	4,0x350	5,0x450
Weight/box [kg]	5	5	5	6,5

Other packaging and other sizes: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.