capilla® 347

Alternatively available:

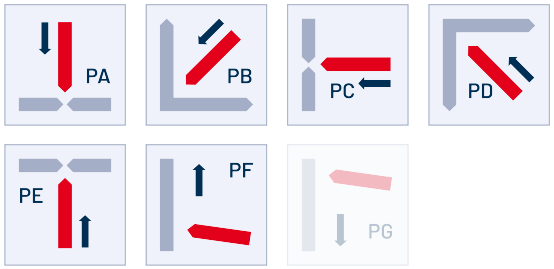
capilla® 347 LR | capilla® 347 WIG | capilla® 347 MAG

EN ISO 3581-A:	**E 19 9 Nb R 12**
EN 1600:	**E 19 9 Nb R 12**
AWS A 5.4:	**E 347 - 16**
Material No.:	**1.4551**
Approval:	**TÜV, DB**

INDICATIVE ANALYSIS [%]

C	Si	Mn	Cr	Ni	Nb	Fe
0,08	**1,20**	**0,80**	**19,50**	**10,00**	**10x %C**	**balance**

WELDING POSITIONS



PROPERTIES:

(without heat treatment; indicative values at room temperature)

Tensile strength Rm	**600 [MPa]**
Elongation (L=5d)	**30 [%]**
Yield strength ReH/Rp0,2	**400 [MPa]**
Impact energy (ISO-V)	**50 [J]**

DIMENSIONS

Ø [mm]	Length [mm]	Welding current [A]
1,6	250	20 - 40
2,0	300	40 - 60
2,5	300	50 - 90
3,2	350	80 - 110
4,0	350	100 - 150
5,0	450	150 - 200

REDRYING 320°C / 2h

CURRENT TYPE =(+) / ~

APPLICATIONS / FEATURES:

Rutile-basic coated stick electrode for welds on stainless austenitic steels.

weld metal made of stabilized austenitic

CrNi steel.

For operating temperatures up to 400°C.

FIELDS OF APPLICATION:

Suitable for base materials such as:

1.4301 (X 5 CrNi 18 10),
1.4303 (X 5 CrNi 18 12),
1.4306 (X 2 CrNi 19 11),
1.4306 (G-X 2 CrNi 18 9),
1.4308 (G-X 6 CrNi 18 9),
1.4310 (X 12 CrNi 17 7),
1.4312 (G-X 10 CrNi 18 8),
1.4319 (X 5 CrNi 18 7),
1.4541 (X 6 CrNiTi 18 10),
1.4550 (X 6 CrNiNb 18 10),
1.4552 (G-X 5 CrNiNb 18 9).

capilla Schweißmaterialien GmbH reserves the right to amend the presented information and values as a result of the ongoing development of the product. The information on mechanical and technological properties always relates exclusively to the weld metal. Approval of suitability for a particular purpose always requires an express written agreement. The revision number indicates the state of knowledge at the time. All information is not legally binding.