Stainless Steel Electrode

ELOX B 347

Standards

TS EN ISO 3581-A	: E 19 9 Nb B 22
EN ISO 3581-A	: E 19 9 Nb B 22
AWS A5.4	: E 347-15

Chemical Composition of Weld Metal % (Typical)

C	Si	Mn	Ni	Cr	Nb
0.04	0.45	1.4	10.2	19.8	0.4

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/+20°C)	Elongation ($L_0=5d_0$) (%))
min. 400	600-740	min. 55 J	min. 30

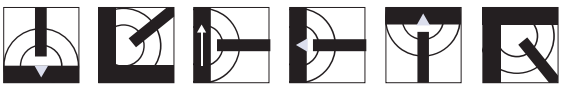
Typical Base Material Grades

- EN & DIN: X6CrNiNb 18 10, X6CrNiTi 18 10, X5CrNi 18 10, X5CrNi 18 10, X2CrNiN 18 10, X2CrNi 19 11, G-X5CrNiNb 19 10, G-X10CrNi 18 8,
- AISI: 347, 321, 304, 304LN, 302, ASTM; A296 Gr.CF8C, A157 Gr C9, A320 Gr B 8C & D

Features and Applications

- Stabilized alloyed-core wire austenitic electrode with basic coating for use in all industries where similar steel types as well as ferritic 13% chromium steels are welded
- High ductility of the weld metal, therefore preferable for welding heavy sections
- Very good out-of-position weldability Good low-temperature-ductility down to -196°C
- Resistant to intergranular corrosion up to 400°C
- Weld metal does not require preheating or postweld heat treatment

Welding Positions



Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101413	2.50 x 250	3/32 x 10”	60-80	1460
3010101418	3.20 x 350	1/8 x 14”	80-120	3250
3010101423	4.00 x 350	5/32 x 14”	100-150	5100

Approvals: TSE, CE, SEPRO