



HILCO HILCHROME 347R

Stick electrodes – stainless steel – acid resistant

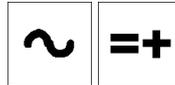
AWS A5.4: E347-17

EN ISO 3581-A: E 19 9 Nb R 3 2

Werkstoffnr. 1.4551

Coating type:
Rutile

Current:



Welding positions:



Hilchrome 347R is our stabilised electrode for welding low carbon 18Cr10NiNb (Cb) austenitic stainless steel grades like AISI 347, 321. Typical applications include all industries where similar materials (incl. higher carbon types) as well as ferritic 13% Cr steels are used. Hilchrome 347R is also suitable for unstabilised grades 304 and 304L. Weld metal has an excellent resistance to general and intergranular corrosion (up to 400°C). Hilchrome 347R is a core wire alloyed all-current type (AC/DC).

Base materials to be welded:

- ASTM/AISI Grade 347, 321, A 296 CF8C, 304, A157 C9, A320 B8C and D, 307L, 304LN, 302
- WNr. 1.4550, 1.4541, 1.4552, 1.4301, 1.4312, 1.4878, 1.6905, 1.4311, 1.4306, 1.4300
- Stabilised CrNiNb 18 10 and similar stainless steel grades

Applications:

- Shipbuilding & Offshore
- Power Generation
- General fabrication & construction
- Repair & Maintenance
- Process Industry

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	Cr	Ni	Nb
0,03	0,8	0,8	19,5	10,0	10xC

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 390	≥ 550	≥ 30	20°C ≥ 55 -120°C ≥ 32

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,5	300	17,5	50-90
3,2	350	34,2	80-120