

ASME II C SFA 5.9 : EQ 347.  
EN ISO 14343-1 : B 19 9 Nb.

## DESCRIPTION

- SOUDOTAPE 347 is a CrNiNb stainless strip designed to make a AISI 347 deposit in the second layer on a previous first layer made either with SOUDOTAPE 24.12LNb + Record INT 102 or SOUDOTAPE 309L + Record INT 109 / EST 136 strip-flux combinations.
- SOUDOTAPE 347 can also used with Record EST 347-1 to reach the full chemical analysis of alloy 347 in one Layer by ESW.

## SUITABLE FOR

- Reactor vessels for petrochemical industry.

## TYPICAL WELD METAL ANALYSIS OF STRIP/FLUX COMBINATION (WEIGHT%)

- Submerged arc strip cladding with RECORD INT 102 / INT 109 on 0.2 % C-steel.

	Flux RECORD	C	Mn	Si	Cr	Ni	Nb	Thickn. (mm)	FN
SOUDOTAPE 347		0.016	1.70	0.4	19.7	10.5	0.5		
2 <sup>nd</sup> Layer	INT 102	0.03	1.0	0.80	19.1	10.2	0.5	4	7
2 <sup>nd</sup> Layer	INT 109	0.035	0.80	0.90	19.3	10.0	0.4	3.1	6

- Electroslag strip cladding with RECORD EST 347-1 / EST 136 on 0.2 % C-steel.

	Flux RECORD	C	Mn	Si	Cr	Ni	Nb	Thickn (mm)	FN
SOUDOTAPE 347		0.016	1.70	0.4	19.7	10.5	0.5		
1 <sup>st</sup> Layer	EST 347-1	0.025	1.20	0.4	18.4	9.7	0.3	4	6
2 <sup>nd</sup> Layer	EST 136	0.016	1.21	0.32	19.0	10.4	0.28	3.0	6

## AVAILABLE STRIP SIZES

- Standard : 60 x 0.5 mm or 30 x 0.5 mm.
- Other sizes on request.

## PACKING

- 60 x 0.5 mm : 50 kg to 60 kg.
- 30 x 0.5 mm : 25 kg to 30 kg.
- Other sizes on request.

**Note** : For additional information about cladding conditions and deposited weld metal properties, please refer to the corresponding flux technical data sheet, cladding data sheet or contact us.