

Standards:

EN ISO 3581-A: E 19 9 Nb R 12
 (EN 1600): E 19 9 Nb R 12
 AWS A 5.4: E 347-17
 Mat.-No.: 1.4551

capilla® 347 LR**Product description:**

Rutile coated stick electrode suitable for welding of Nb- and/or Ti-stabilized, austenitic stainless steels. Weld deposit consists of stabilized austenitic CrNi-steel. Service temperatures up to 400°C.

Applications:

Suitable for materials as:
 1.4301, 1.4303, 1.4306, 1.4308,
 1.4310, 1.4312, 1.4319, 1.4541,
 1.4550, 1.4552.

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Nb	Fe
Min.		18	9	10 x %C	
Max.	0,03	20	11		Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	600	[MPa]
Yield strength $R_{p0,2}$:	400	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	30	[%]
Impact strength (ISO-V):	65	[J]

Positions: all

Redrying:: 300°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,0	300	40 – 60	= (+) ~
2,5	300	50 – 90	
3,25	350	80 – 110	
4,0	350	100 – 150	
5,0	450	150 – 200	

also available:
 find in table of content

Capilla 347
 Capilla 347 MAG

Capilla 347 WIG