

GM-347

Classification:

AWS A/ 5.4 : E347-16

IS-5206 : E 19.9 Nb R26

Description:

GM-347 is a 19/10 Nb stabilized stainless steel electrode for welding of AISI 304, 308, 321 & 347 grades. Weld metal shows maximum resistance to cracking & gives excellent chemical & mechanical properties. Suitable for Chemical, Food, Refineries and Power plants.

Applications:

- ❖ Welding of AISI 304, 308, 321 and 347 grades.
- ❖ Cladding of carbon steels and low alloy steels.
- ❖ Fabrication of equipments in refineries, chemical industries, power plants, centrifugal pump impellers and shafts, valve seats etc.

Chemical Composition of Weld Metal (WT. %):

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	Nb+Ta
0.08 Max	0.50 - 2.50	1.00 Max	0.030 Max	0.040 Max	9.0 - 11.50	18.0 - 21.0	0.75 Max	0.75 Max	8 X C% - 1.00

Mechanical Properties of Weld Metal:

Tensile Strength (N/mm ²)	Elongation L=4d (%)
520 Min	30 Min

Current Conditions: AC (70 V) / DC (+)

Size (mm)	2.50 X 350	3.15 X 350	4.00 X 350	5.00 X 350
Current (Amps)	60 - 80	80 - 110	110 - 140	150 - 180

Welding Positions: F, H, V-up, OH

Recommendation:

Re-dry the electrodes at 250°C for 1 hour. Keep the re-dried electrodes in holding oven before use (70 to 100°C). Use electrodes within recommended current conditions for better performance.

Caution:

Protect yourself and others. Fumes & gases can be dangerous to health. Arc rays can injure eyes and burn skin. Electric shock can kill. Refer American National Standard Z49.1 "Safety in welding and cutting".

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