

Key Facts

- Stable, well directed arc
- Smooth bead formation
- Clean weld edge
- Low spatter loss with easy slag removal.

Description

A rutile coated electrode for welding corrosion resistant, stabilised CrNi steels. Produces a smooth weld through a well directed arc with a clean edge. Welding positions; flat, horizontal and vertical-up.

Welding Positions

Flat, horizontal, vertical-up and overhead.

Classification

AWS A5.9: ER347

Recommended Shielding Gas

The most frequently used shielding gas is pure argon (Ar) with a gas flow of 12-17 ft³/hour (6-8 l/min).

Markings & Identification

End tip Colour: Gold
End side Colour: Grey
Printing: GEMINI 347

Applications

Suitable for stainless and applications of heat resistant steel up to 800°C, especially 321, 347 and 348.



Typical All Weld Metal Analysis

Carbon	Manganese	Silicon
0.050%	0.80%	0.70%
Ni - Nickel	Cr - Chromium	Nb - Niobium
9.500%	19.000%	0.20%

Typical All Weld Metal Mechanical Properties

Yield Strength:	500N/mm ²
Tensile Strength:	650N/mm ²
Elongation (5xD):	30%
Reduction of Area:	50%
Impact Strengths ISO-V	50J @ +20°C

Packaging & Ordering Information

Size	Packet	Ctn	Current Range	Part Number
2.6mm	1kg	20kg	50-80	100026
3.2mm	1kg	20kg	70-110	100027

Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary from model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products this is entirely up to the user's ability.