

Stainless rutile cored wire

Classification

AWS A5.22 :E 347T0-4
 ISO 17663 :T 19 9 Nb R M 3

General description

Rutile gas shielded stainless steel wire electrode for downhand welding
 For Ti or Nb stabilized 304 or equivalent steels
 Excellent resistance in oxidizing environments such as nitric acid
 High resistance to intergranular corrosion
 Easy slag release and smooth bead appearance

Welding positions



ISO/ASME PA/1G PB/2F PC/2G

Current type / Shielding gases

DC +
 Ar+(>5-25)% CO₂ (EN 439:M21)
 15-25 l/min

Typical chemical composition of all weld metal, (w%)

Shielding gases	C	Mn	Si	Cr	Ni	Nb	FN
M21	0.03	1.6	0.45	19.1	10.4	0.65	8

Mechanical properties of all weld metal

	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact (ISO), J	
						+20°C	-20°C
Required	AWS A5.22 ISO 17663		not required min 350	min 520 min 550	min 30 min 25		
Typical values after welding	M21	AW	460	610	39		65

Packaging, available sizes and identification

Unit type	Net weight/unit (kg)	Diameter (mm)
Wire reel B202	5	1.2
Plastic spool S300	12.5	X

Identification Imprint: Cor-Revicod®347LT0

Cor-Revicod®347LT0: rev. EN 20

Materials to be welded

Steel	EN 10088-11-2	EN 102 13-4	W.Nr.	ASTM/ACI A240/A312/A351	UNS
Ti-, Nb- stabilized	X6 CrNiTi 18 10		1.4541	(TP)321	S32100
				(TP)321H	S32109
	X6 CrNiNb 18 10		1.4550	(TP)347	S34700
				(TP)347H	S34709
Non stabilized		GX5 CrNiNb 19 10	1.4552	CF-8C	J92710
				302	
		X4CrNi 18 10	1.4301	(TP)304	S30400
				(TP)304L	S30403
		X2CrNi 19 11	1.4308	CF-8	J92600
				1.4312	(TP)304H

Welding parameters, optimum fill, Shielding gases M21/C1

Diameter (mm)	Current / Voltage	Welding position				
		PA/1G	PB/2F	PC/2G	PF/3G up	PE/4G
1.2		100-250	100-250	100-200		