

DIFFUSALLOY 347

A specially designed “lo temp” austenitic stainless steel electrode for all position welding of stabilized austenitic stainless steel grades, like aisi 321, 347 etc. The special additions make the weld metal resistant to intergranular corrosion.

Applications:

For production and maintenance welding of aisi 321, 347 etc stainless steels. Excellent for applications in dairy, food, chemical and nuclear plants. Since the weld metal is stabilized, it is not susceptible to sensitization, i.e. Chromium carbide precipitation.

Procedure:

preheat electrode to 150⁰c to reduce moisture. Clean weld area and provide clamps/back up plates to minimise distortion on thin plates. Tack-weld at short intervals. Use electrode on ac/dc+ at lowest possible amps. Maintain very short arc and chip slag between passes. Avoid weaving.

Major Alloying Element:

C	Cr	Ni	Nb
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<u>Technical Data</u>	:	DIFFUSALLOY 347			
Size (mm)	:	2.5	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	40 – 70	70 – 100	90 – 130	130 - 160
Tensile Strength	:	53 kgf / mm ²			
Elongation	:	30% (Min.)			
CVN Impact Strength at 20 ⁰ C	:	8 – 12 kgfm / cm ²			
Tip Colour	:	Light Green			

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