

## Classifications

<b>EN ISO 3581-A</b>	<b>AWS A5.4 / SFA-5.4</b>
E 19 9 Nb B	E347-15

## Characteristics and typical fields of application

Basic coated electrode of E 19 9 Nb B / E347-15 type for welding of CrNi-alloyed austenitic stainless steels such as 1.4541 / 347H for service temperatures up to 400°C. Controlled ferrite content of 3 – 8 FN. The deposit is less susceptible to embrittlement and scaling resistant. Excellent weldability in all positions except vertical down.

## Base materials

1.4541 X6CrNiTi18-10, 1.4550 X6CrNiNb18-10, 1.4878 X8CrNiTi18-10, 1.4912 X7CrNiNb18-10, 1.4940 X7CrNiTi18-10  
UNS S32100, S32109, S34700, S34709  
AISI 321, 321H, 347, 347H

## Typical analysis


	C	Si	Mn	Cr	Ni	Nb	FN
wt.-%	0.05	0.3	1.3	19.0	10.2	0.56	3 – 8

## Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength $R_{p0.2}$	Tensile strength $R_m$	Elongation A ( $L_0=5d_0$ )	Impact energy ISO-V KV J
	MPa	MPa	%	20°C
u	460 ( $\geq 350$ )	635 ( $\geq 550$ )	40 ( $\geq 25$ )	100 ( $\geq 32$ )

u untreated, as-welded

## Operating data

	Polarity	DC+	Dimension mm	Current A
	Electrode identification	FOX E 347 H-15 E 19 9 Nb B	2.5 × 300	50 – 80
		3.2 × 350	75 – 110	
		4.0 × 350	110 – 145	

Preheating is not required; only in case of wall thickness above 25 mm preheat up to 150°C.  
Interpass temperature should not exceed 200°C.

## Approvals

CE