

Classifications

EN ISO 14343-A	EN ISO 14343-B	ASME II C SFA 5.9
B 22 12 L Nb	BS309LNbD	(EQ347)

Characteristics and typical fields of application

• SOUDOTAPE 21.11LNb is an overalloyed niobium stabilised austenitic stainless steel strip electrode to produce single layer weld overlay of corrosion resistant stainless steel type 347 (1.4550). For improved corrosion resistance, a second layer with SOUDOTAPE 347 is optional.

- SOUDOTAPE 21.11LNb is also suitable for buffer layer.
- SOUDOTAPE 21.11LNb is widely used to get improved resistance to intergranular corrosion at high temperature.
- SOUDOTAPE 21.11LNb has restricted cobalt content for nuclear applications.

347 weld overlay may also be stress relieved within the carbide precipitation range from 425°C to 800°C, without any danger of subsequent intergranular corrosion.

Typical application are pressure vessels like hydrocrackers in petrochemical industry.

Typical analysis

	C	Si	Mn	Cr	Ni	Nb	N	Fe
wt.-%	0.01	0.3	1.7	21.6	11.2	0.6	0.04	Rem.

Typical fluxes to combine

Process	Name	EN ISO 14174
ESW	RECORD EST 122	ES A FB 2B
ESW	RECORD EST 501	ES A FB 2B
SAW	RECORD INT 109	S A CS 2B

Packaging

Size(s) in mm	Type	Weight
30 x 0,5	Coil	25 - 30 kg
60 x 0,5	Coil	50 - 60 kg
90 x 0,5	Coil	75 - 90 kg

Other sizes and coil weights on request.