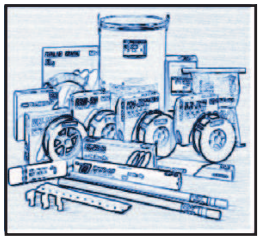
Shielded Metal Arc Welding

ANU BOND - 1B (E 347 -16)

AWS: SFA 5.4, E347 - 16, IS:5206 E 19.9 Nb R26

Stainless Steel Electrodes



Application :

AISI steels 321 and 347 generally on 18/8 steels stabilised by Titanium or Niobium in the manufacture of equipment for chemical, food & aircraft industries, also used for welding unstabilized stainless steels of AISI 301, 302, 304,& 308 types.

Characteristics on Usage :

A lime titania all position electrode which is almost spatter free, has a smooth arc, which excellent weld bead finish and self lifting slag. A Niobium stabilised stainless steel of 19 Cr - 10 Ni type weld metal has excellent creep strengths and is of radiographic quality. Welding can be done on AC or DC (+) polarity, high degree of corrosion resistance in oxidising environment such as nitric acid.

Chemical composition of All-Weld metal (%) as per AWS

C	Mn	Si	S	P	Cr	Ni	Nb (Cb)+Ta
0.080 Max	0.50-2.50	1.0 Max	0.030Max	0.040 Max	18.0-21.0	9.0-11.0	0.50 -0.90

Mechanical properties of all-weld metal as per AWS

UTS (N/mm^2)	Elongation (L=4d) %
520 Min	30 % Min

Welding Positions

Packaging & Welding Current

SIZE (mm)	KG Per Packet	KG Per Carton	Current (Amps)	In Amps
2.50 x 350	2	12	AC/ DC (+)	45-80
3.15 x 350	2	12		85-120
4.00 x 350	2	12		100-140
5.00 x 350	2	12		140-180