

BASINOX 347 is a basic coated MMA electrode for welding similar stabilised austenitic stainless, Cr-Ni steels or cast steels. With the correct welding procedure, also suitable for stainless or heat-resistant ferritic Cr steels. Structural works with similar stabilised stainless steels in all positions except vertical down. The weld metal has high ductility and BASINOX 347 is recommended for welding thicker section components. Applications include wet-corrosive conditions for operating temperatures <350°C, non-scaling <800°C. Easy slag release and well-suited for positional welding.

Classification	
AWS	A5.4: E 347-15

Approvals	Grade
DB	●
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Nb	Ferrite
0.05	1.6	0.45	≤ 0.030	≤ 0.025	19	9.5	0.5	5-10

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-60 °C
As Welded	≥ 420	≥ 600	≥ 25	≥ 70	≥ 40

Materials

AISI 347 - 321

1.4541 (X6CrNiTi18-10); 1.4301 (X4CrNi18-10); 1.4550 (X6CrNiNb18-10);

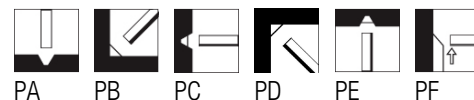
Storage

Keep dry and avoid condensation.

Re-dry at 250°-300°C for 1 hour, 5 times max.

Current condition and welding position

DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	VPMD	
				PC	Code
2.5	300	45-70	17.68	110	W000287977
3.2	350	65-120	33.19	65	W000287978
4.0	350	115-140	48.2	45	W000287979
4.0	450	115-140	62.70	45	W000380283
5.0	350	130-170	76.0	30	W000287980
5.0	450	130-170	97.7	30	W000380284