AI-0247T

Specifications

AWS/ASME 11C SFA 5.4 E347-16
ISO 3581: E 19. 9 Nb R 23
BS 2926 - 1984 19.9 Nb R

Description and Applications

Rutile coated electrode for welding similar material or for a substrate to provide a strong base for subsequent harder materials.
Deposit is stabilised with Nb to control intergranular corrosion in corrosive media and at elevated temperatures.
AI-0247T has exceptional weldability, the ability to weld at very low current (thus minimizing heat input) and has automatic slag removal.

Typical Weldmetal Analysis

C	Mn	Si	Cr	Ni	Fe	Nb	FN
0.02	0.85	0.80	18.8	9.40	Bal	0.28	6

Mechanical Properties of Weldmetal

	As Welded
Tensile Strength:	600 MPa
Yield Strength (0.2%):	450 MPa
Elongation:	22% (4d)
Microstructure:	Austenite + Ferrite
Av (ISO - V):	40 J: -105 ^{0}C
Shielding Gas	100 % Argon

THE TIG ELECTRODE HAS THE 347CORE AND THE WELD DEPOSIT IS AS SHOWN IN THE ABOVE WELD METAL ANALYSIS.

Welding Parameters

Diameter (mm)	Current type	Shielding Gas
1.6 x 1000	DC (-)	I 1
2.4 x 1000	DC (-)	I 1

Disclaimer

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