

## AI-0247

### 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-0247** 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 °C

### Welding Parameters

Diameter (mm)	Current type	Amps
1.6	DC /AC	25-40
2.0	DC /AC	40-60
2.5	DC /AC	50-90
3.25	DC /AC	80-120
4.0	DC /AC	110-160
5.0	DC /AC	140-200

Also available as TIG: **AI-0247T**

### Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position, (4G) Overhead position, (3G, 3F, 5G up) Vertical Position Up

### Disclaimer

All figures in this datasheet should be considered indicative only. No guarantee is made as to their accuracy.

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