

BASINOX 347

TOP FEATURES

- Easy slag release.
- Well-suited for positional welding.
- Applications include wet-corrosive conditions for operating temperatures up to 350°C, non-scaling up to 800°C.

CLASSIFICATION

AWS A5.4 E347-15

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

TÜV	DB
+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

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

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					+20°C	-60°C
AWS A5.4	AW	not specified	≥520	≥25	not specified	not specified
EN ISO 3581-A	AW	≥320	≥510	≥25	not specified	not specified
Typical values	AW	420	600	35	70	40

AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	45-70
3.2 x 350	65-120
4.0 x 350	115-140
4.0 x 450	115-140
5.0 x 350	130-170
5.0 x 450	130-170

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	VPMD	110	1.9	W100287977
3.2 x 350	VPMD	65	2.2	W100287978
4.0 x 450	VPMD	45	2.8	W100380283
5.0 x 450	VPMD	31	2.9	W100380284

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.