

Cor-A-Rosta® 347

TOP FEATURES

- For Ti or Nb stabilized 304 or equivalent steels.
- Excellent resistance in oxidizing environments such as nitric acid.
- High resistance to intergranular corrosion.

TYPICAL APPLICATIONS

- Chemical and petrochemical industry
- Welding of stabilized austenitic stainless steels.

CLASSIFICATION

AWS A5.22 E347T0-1/4
 EN ISO 17633-A T 19 9 Nb R C/M 3

CURRENT TYPE

DC+

WELDING POSITIONS

Flat/Horizontal

SHIELDING GASES (ACC. EN ISO 14175)

M21 Mixed gas Ar+ 15-25% CO₂
 C1 Active gas 100% CO₂
 Gas flow 15-25l/min

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

Shielding gas	C	Mn	Si	Cr	Ni	Nb	FN (acc. WRC 1992)
M21	0.05	1.4	0.6	19.5	10	0.5	5

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
Required: AWS A5.22			not specified	min. 520	min. 30	
EN ISO 17633-A			min. 350	min. 550	min. 25	
Typical values	M21	AW	435	600	42	90

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (S300)	15.0	585544

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.