

Ultramet™ 347H

TOP FEATURES

- All-positional rutile MMA electrode for 321H/347H stainless steels
- Recovery is about 110%

TYPICAL APPLICATIONS

- Petrochemical and chemical process plants
- Cyclones and transfer lines in catalytic crackers

CLASSIFICATION

AWS A5.4 E347-16
EN ISO 3581-A E 19 9 Nb R 3 2

CURRENT TYPE

DC+/AC

WELDING POSITIONS

All position, except vertical down

CHEMICAL COMPOSITION (WEIGHT %), WELD METAL

	C	Mn	Si	S	P	Cr	Ni	Mo	Nb *	Cu	FN
Min.	0.04	0.5	not specified	not specified	not specified	18.0	9.0	not specified	8xC	not specified	2
Max.	0.08	2.0	0.9	0.025	0.030	21.0	11.0	0.50	1.00	0.50	8
Typical	0.05	0.7	0.7	0.01	0.02	19	9.5	0.05	0.5	0.07	4

*BS requires 10xC minimum.

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

As-welded	Room temperature		High Temperature		
	Min.	Typical	650°C	732°C	815°C
Tensile strength (MPa)	560	650	354	308	233
0.2% Proof strength (MPa)	350	500	283	269	206
Elongation (%)	4d	40	-	-	-
	5d	25	19	20	7
Reduction of area (%)	not specified	52	47	38	23

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	60-90
3.2 x 350	75-120
4.0 x 350	100-155

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	CAN	210	3.7	UM347H-25-1
3.2 x 350	CAN	115	4.2	UM347H-32-1
4.0 x 350	CAN	77	4.1	UM347H-40-1

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.