

EZ - KROM 10 Nb

CLASSIFICATION

EN ISO 3581-A	AWS / ASME SFA-5.4
E 19 9 Nb R 12	E347-16

DESCRIPTION AND APPLICATION

A rutile type coated electrode for welding of identical (stabilized) and similar stainless steels. The weld metal is of austenitic Cr-ni type with low carbon, stabilized with niobium, resistant to intergranular corrosion up to 400°C and oxidation up to 800°C. Weld metal structure is austenite with delta ferrite.

Steel grade	HRN	DIN (W. Nr.)	ASTM / AISI	EN / ISO
High alloyed	Č 4582	X6 CrNiNb 18 10 (1.4550)	347	X6CrNiNb18-10
austenitic	ČL 4572	G-X5 CrNiNb 18 9 (1.4552)	-	GX5CrNiNb19-11
stainless steels	Č 4572	X6 CrNiTi 18 10 (1.4541)	321	X6CrNiTi18-10
and casts	Č 4580	X5 CrNi 18 11 (1.4301)	304	X5CrNi18-10
	Č 4571	G-X10 CrNi 18 8 (1.4312)	-	GX10CrNi18-8
	Č 45701	X2 CrNi 19 11 (1.4306)	304 L	X2CrNi19-11
	ČL 45701	G-X6 CrNi 18 9 (1.4308)	-	GX5CrNi19-10

MECHANICAL PROPERTIES OF THE ALL-WELD METAL

R _{p0.2} N/mm ²	R _m N/mm ²	A ₅ %	KV (20°C) J
> 400	600 - 700	> 30	> 60

APPROXIMATE CHEMICAL COMPOSITION OF THE ALL-WELD METAL

	C	Mn	Si	Cr	Ni	Nb
%	≤ 0,03	0,9	0,9	19	10	> 10x%C

RECOMMENDED WELDING CURRENT

Ø mm	2,5	3,2	4,0
A	60 - 90	80 - 130	110 - 160

PACKAGING

Electrode dimensions mm	Quantity per ton approx. pieces	Weight of packaging kg
Ø 2,5 x 300	52 800	1,1
Ø 3,2 x 350	26 300	1,1
Ø 4,0 x 350	18 200	1,2



Marking: **E 347-16**
Dry before use 2h/300°C