

Stick Electrode for Stainless Steel

KS-347

Classification

AWS	A 5.4	E347-16
JIS	Z3221	ES347-16
EN	3581-A	E 19 9 Nb
GB	T 983	E347-16

Type of coating: Lime titania type

Applications and Features

- (1) Weld metal is 19.5%Cr-10%Ni.
- (2) It provides good corrosion resistance and high strength at high temperature due to its additional Nb content.
- (3) It is suitable for welding heat resistant steel, AISI 347, 321,304L and ASTM CF-8 stainless steel castings.

Welding Position

All Positions

Welding Instruction

- (1) Please refer to Appendix H for re-drying instructions.
- (2) For other instruction information, please refer to Appendix F.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S	Cr	Ni	Nb
0.060	0.35	1.30	0.012	0.009	19.50	9.45	0.60

Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm ² (kgf/mm ²)	Yield Strength N/mm ² (kgf/mm ²)	Elongation %
590(60.1)	420(42.8)	42

Size and Suggested Operating Range (AC or DC+)

Diameter x Length (mm)	2.0x250	2.6x300	3.2x350	4.0x350	5.0x350	
Amp	F/H-Fillet	35~55	50~85	80~120	100~150	140~200
	V-up/OH	30~50	45~85	70~110	90~135	—