



**347-16**

AC/DC+

**STAINLESS STEEL**

**DESCRIPTION**

Rutile-basic coated electrode 18%Cr-8%Ni type stainless steel Niobium / columbium stabilised, suited to weld Ti or Nb stabilised stainless steels. The weld metal contains about 8% delta ferrite. Soft fusion without spatters, easy striking and restriking- very easy slag removal. The weld deposit is resistant to intercrystalline corrosion. Good moisture resistance.

**CLASSIFICATION**

AWS A5.4 : E347-16      EN 1600 : E 19 9 Nb R 32      ISO 3581-A : E 19 9 Nb R 32

**BASE MATERIALS:** 304, 304L, 321, 347

**PROCEDURE**

Re-drying: 1h at 250°C. Interpass temperature : < 2 00°C.

**MECHANICAL PROPERTIES**

Tensile strength:      > 80 000 psi (> 550 MPa)  
 Yield strength:      > 50 800 psi (> 350 MPa)  
 Elongation:      > 30 %  
 Impact (Charpy V):      > 60 J at +20°C

**TYPICAL WELD METAL COMPOSITION (%)**

C	Mn	Si	Ni	Cr	Nb
<0.03	0.70	0.80	9.5	19.5	0.3

**WELDING PARAMETERS**

Diameter:	5.0 mm (3/16")	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")	2.0 mm (5/64")
Amperage:	180 A	135 A	100 A	70 A	45 A

**WELDING POSITIONS**



1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

Rév. :7\_01

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