

Stainless Steel SMAW Electrodes

G347

AWS A5.4 E347-16
JIS Z 3221 ES347-16
ISO 3581-A-E 19 9 Nb R 1 2

Product Features:

- Austenite weld metal contains adequate ferrite to get low crack sensitivity.
- Weld metal contains Nb element to get good inter-granular corrosion resistance.
- Good high temperature creep strength, acid and heat resistance.

Applications:

- Welding of SUS321 to 304L, 309, 309S.
- Welding of SUS347, 348 to 304L, 308, 309, 310S, 316, 317 and 321, etc.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Ni	Cr	Nb	Fe
0.03	0.81	0.73	9.8	18.5	0.48	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-196°C) J
515	622	43	60

Size (mm) & recommended welding parameters (A) AC or DC+

Diameter / Length	2.6/300	3.2/350	4.0/350	5.0/350
Flat position	60~85	85~120	115~150	150~200
Vertical / overhead position	50~70	75~105	95~130	----

Note:

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