

# Stainless Steel SMAW Electrode

## G347H

AWS A5.4 E347-16  
JIS Z 3221 ES347-16

### Product Features:

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

### Applications:

- Welding of SUS347, 304 to 304L, 321, etc.

Typical chemical composition of weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Nb
0.06	0.59	0.79	0.025	0.004	9.40	19.5	0.80

Typical mechanical properties of weld metal

Tensile Strength N/mm <sup>2</sup>	Elongation %	FN
643	37.6	6.5

Size (mm) & recommended welding Current Range (AC/DC+)

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

### Note:

- 250~300°C× 1 hr baking prior to use.
- Proper cleaning of welding groove or joint surface before welding and complete removal of spatter after welding.
- Recommending low electrical current for avoiding defects such as core wire overheat and coating peeling off.

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