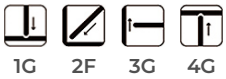
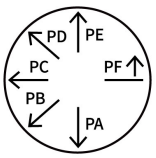
S-347.16

Classification

AWS A5.4/ASME SFA-5.4 E347-16
JIS Z 3221 ES347-16
EN ISO 3581- A E 19 9 Nb R
KS D7014 E347-16

Welding Positions





Features

- Contains stabilizing element(Nb)
- High temperature strength
- Suitable for welding of boiler and gas turbine
- Easy to remove slag

Polarity

AC or DC+

Application Areas

- Stainless steel (321, 347)

Redrying Conditions

350°C (662°F) X 1hr

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S	Cu	Ni	Cr	Mo
0.03	0.67	0.8	0.030	0.014	0.03	9.8	18.6	0.03

Typical Mechanical Properties of All-Weld Metal

Tensile Strength MPa(ksi)	Elongation (%)
603(88)	41

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.0 (5/64)	300 (12)	25~55	20~50	PVC - Packet 2.5kg(5.5lbs), Carton 10kg (22lbs)
2.6 (3/32)	300 (12)	50~85	45~80	
3.2 (1/8)	350 (14)	70~115	65~110	
4.0 (5/32)	350 (14)	95~145	85~135	
5.0 (3/16)	350 (14)	135~180	-	