

E347-16

AWS A5.4 E347-16
ISO3581-A-E19 9 Nb R
GB/T 983 E347-16

Description:

A niobium-stabilized Cr19Ni10Nb stainless steel electrode designed to weld titanium and niobium-stabilizer steels. It is particularly suitable for high temperature applications, with excellent intergranular corrosion resistance performance. Used to weld S347, S321, 18-18-Nb and 18-8-Ti steels.

Welding Position:



Diameters:

2.5mm, 3.2mm, 4.0mm, 5.0mm.

Typical Mechanical Properties:

Tensile strength(MPa):	610
Yield strength(MPa):	--
Elongation(%):	38

Typical Chemical Composition:

C	Mn	P	S	Si	Ni	Cr	Nb	Cu
0.051	0.85	0.025	0.003	0.68	9.6	19.8	0.35	0.15

Welding Current:(AC/DC±)

Diameter(mm)	2.5	3.2	4.0	5.0
Current/A	F/H 60-90	80-120	100-140	150-210
Current/A	V/OH 40-70	60-100	80-140	-

Note:

- 1.The electrodes should be baked 1 hours in 300-350℃ before using.
- 2.Welding in short arc,and swing scope should not exceed 2.5 times of the electrode diameter.