

S-347.16

TYPE : Rutile

AWS A5.4 / ASME SFA5.4 E347-16
JIS Z3221 ES347-16
EN 1600 - E 19 9 Nb R

Applications

Welding of 321, 347 stainless steel.

Characteristics on Usage

S-347.16 is a lime-titania type electrode and all-weld metal has an austenite structure.

As the all-weld metal contains small amount of stabilizing element(Nb), its resistance to corrosion is good.

As the all-weld metal has an excellent high temperature strength, it is suitable for welding of boiler and gas turbine.

Notes on Usage

- ① Dry the electrodes at 350°C(662°F) for 60 minutes before use.
- ② Remove rust, water, oil and paint from the surface to be welded.
- ③ Keep the arc as short as possible.

Welding Position



1G 2F 3G 4G
(PA) (PB) (PF) (PE)

Current

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Nb
0.02	0.75	0.82	0.027	0.014	18.5	9.8	0.36

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)
603 (87,600)	42.4

Approval

I Packing

Packet 2.5 kg (5.5 lbs)
Carton 2.5 kg (5.5 lbs) × 4 : 10kg(22 lbs)

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.0 (5/64)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm(in)	300 (12)	300 (12)	350 (14)	350 (14)	350 (14)
F	25~55	50~85	70~115	95~150	135~180
V-up, OH	20~50	45~80	65~110	85~135	-