

TS-347

AWS A5.4 E347-16
EN ISO 3581-B-ES347-16
JIS Z 3221 ES347-16

Characteristics and Applications:

The product provides good inter-granular corrosion resistance and heat resistance due to its Nb content. It is suitable for the welding of chemical vessels, steel strip, heat transfer tube, seamless pipe, steel bar and AISI 347, 321, 304L steel plates.

Notes on usage:

1. Clean up the contaminations on the base metal, groove and pass to pass with stainless steel brush.
2. Maintain short arc length. Moving range should be controlled within 2.5 times of the wire's dia when you are welding with weave method.
3. Dry the electrodes at 250~300°C for 60 minutes before using. Take out consumables for half day consumption and keep in the environment at 100~150°C during welding process.
4. Use lower current to prevent from crack and minimize base metal dilution.

Typical chemical composition of weld metal (wt%):

	C	Mn	Si	P	S	Cr	Ni	Nb
AWS	≤0.08	0.5-2.5	≤1.00	≤0.04	≤0.03	18.0-21.0	9.0-11.0	8xC-1.00
EN ISO	≤0.08	0.5-2.5	≤1.00	≤0.04	≤0.03	18.0-21.0	9.0-11.0	8xC-1.00
Typical value	0.032	1.30	0.50	0.035	0.010	20.00	9.50	0.35

Typical mechanical properties of weld metal:

	Tensile strength MPa(ksi)	Elongation %
AWS	≥520(75)	≥30
EN ISO	≥520(75)	≥25
Typical value	600(87)	38

Welding position:



Sizes and recommended current range (AC or DC<+>):

Diameter (mm)	2.6	3.2	4.0	4.8
Length (mm)	300	350	350	350
Amps	F	60-90	80-130	130-170
	V&OH	50-70	70-110	100-130

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