S-347.16

Type : Rutile

Conformances

AWS A5.4/ ASME SFA5.4 E347-16

JIS Z3221 ES347-16

EN ISO 3581-A-E 19 9 Nb R

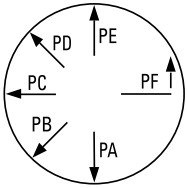
Applications

- Stainless steel (321, 347)

Features

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

Welding Position



Current

AC or DC ±

Redrying Conditions

350°C (662°F) X 1hr

Diameter / Packaging

Diameter		Length	P.V.C	
mm (in)		mm (in)	packet	carton
			2.5kg(5.5lbs)	10kg(22lbs)
2.6 (3/32)		350 (14)	√	
3.2 (1/8)		350 (14)	√	
4.0 (5/32)		400 (16)	√	
5.0 (3/16)		400 (16)	√	
6.0 (15/64)		450 (18)	√	

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	19.3	9.8	0.35

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in²)	EL (%)
603 (87,600)	42.4

Typical Welding Parameters / Amp.(A)

Diameter 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 & HF	25~55	50~85	70~115	95~145	135~180
V-up, OH	20~50	45~80	65~110	85~135	-