

**Classifications**

EN ISO 3581-A:2012	: E 19 9 Nb B 12	KS D 7014	: E347-16
EN ISO 3581-B:2012	: ES347-16	JIS Z 3221	: ES347-16
AWS A5.4-06	: E347-16		

**Description**

- Covering is lime titania type for welding of AISI 304L, 321, 347 stainless steel and the place where heat treatment after welding is impossible.
- Excellent intergranular corrosion resistance.
- Redry the electrode at 250~350°C for 30-60 minutes prior to use.

**Welding positions****Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	Cu	FN
0.03	0.49	1.94	0.026	0.004	9.83	19.16	0.48	0.10	7.3

\* FN : WRC 1992

**Typical mechanical properties of all-weld metal**

	Y.S(0.2%OS) (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				R.T	-20°C	
AWS A5.4		min. 520	min. 30			
EN ISO 3581-A	min. 350	min. 550	min. 25			
Example	430	620	40	80	65	AW

\* AW : As-Welded

**Sizes available and recommended currents (AC or DC +)**

Dia.	(mm)	2.0	2.6	3.2	4.0	5.0
Length	(mm)	250	300	350	350	350
Amp.	F	40-60	50-70	70-110	100-150	140-180
(A)	V · OH	35-45	45-60	65-90	90-130	-

**Approvals**

CE