

ES 347-16

SMAW

ESWECO
The Art of Welding

Type Rutile

E347-16

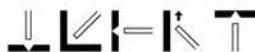
Description

ES 347-16 is a niobium-stabilised, stainless welding electrode for titanium- and niobium-stabilised 18-8 steel. It is particularly suitable for high-temperature applications.

Typical application: Process Piping, Power Generation Equipment, Welding 321 and 347 Stainless Steels, Food Processing and Pharmaceutical Equipment

Current

DC+, AC OCV 60 V



Classifications

EN 1600	E 19 9 Nb R 3 2
SFA/AWS A5.4	E347-16
Werkstoff Nr.	1.4551

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Nb	Cu
0.06	0.7	1.6	20.0	10.0	<0.3	<1.0	<0.3

Typical mech. Properties all weld metal

Yield stress, MPa	560
Tensile strength, MPa	700
Elongation A4, %	31

Charpy V

Test temps, °C	Impact values, J
+20	60

Ferrite content FN 6-12

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	300	50-80	30
3.2	350	70-115	32
4.0	350	110-160	33