

Classifications

EN ISO 3581-A:2016	E 19 9 Nb R 12	KS D 7014-2008	E347-16
EN ISO 3581-B:2016	ES347-16	JIS Z 3221-2013	ES347-16
AWS A5.4-2014	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 (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				RT	-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

* Please refer to our homepage(www.kiswel.com) for further detailed information regarding approvals.