347

SPECIAL WELDING ROD FOR STAINLESS STEEL TYPES AISI 301, 302, 304 ,308,321 AND 347. IT IS STABILIZED WITH COLUMBIUM TO AVERT CHROMIUM CARBIDE PRECIPITATION.

CLASSIFICATION A.W.S: E-347-16

APPLICATIONS: It is recommended for applications where corrosion together with high temperatures create problems. It is commonly used in chemical facilities, oil refineries, distilleries, paper industries and in heat treatment facilities. It is also used to clad steel. It is used in milk condensers, skimming equipment and also in store tanks for chemicals.

CHARACTERISTICS AND PROCEDURE: 347 is used to weld stainless steel but it is specially effective on types 321 and 347 where top corrosion resistance is required. This welding rod has been formulated with special components to avert the precipitation of carbides. This normally takes place in alloys of this kind whenever they are submitted to temperatures around 650° C. Clean the base metal to remove dirt, scales, grease and rust. Use the lowest possible AMP. Keep the arc short and tilt the welding rod slightly in the same direction as the weld. Let the slag stand on the filler metal till it all cools down. Avoid overheating the base metal. Remove the slag completely between one pass and the next.

TENSILE RESISTANCE:	6,327 KG./CM2 (90,000 PSI)
BRINELL HARDNESS:	235 BHN
ELONGATION:	40%
FERRITE No.:	0
POSITIONS:	ALL
CURRENT:	AC OR DC REVERSE POLARITY

FILLER METAL CHEMICAL ANALYSIS %						SIZES	AMPERAGE
C	**Mn**	**Si**	**Cr**	**Ni**	**Cb**	2.38 mm-3/32"	50-70
0.06	1.80	0.90	19.5	9.5	0.80	3.25 mm - 1/8"	80-100
						4.0 mm - 5/32"	110-130
						5.0 mm - 3/16"	140-170