

Covered Electrodes

KST-347L

For stainless steel (Low C, 18%Cr-8%Ni-Nb)

Classifications

KS D 7014 : E347L-16
JIS Z 3221 : ES347L-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	Nb
0.03	0.46	1.85	0.028	0.005	9.80	19.35	0.20	0.68

Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
JIS Z 3221		min. 510	min. 30	
Example	440	600	39	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. (A)	F	40~60	55~80	80~110	110~140	140~170
	V · OH	35~45	45~60	70~90	90~130	-