

KS-347

Classification

AWS A 5.4/A5.4M E347-16

Type of coating: Lime titania type

AS/NZS 4854 B ES347-16

Applications and Features

- (1) Weld metal is 19.5%Cr-10%Ni.
- (2) Good corrosion resistance and high strength at high temperature due to additional Nb content.
- (3) It is suitable for welding heat resistant steel, AISI 347, 321,304L and ASTM CF-8 stainless steel castings.

Welding Position

All Position

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Cr	Ni	Nb
0.060	0.35	1.30	0.012	0.009	19.50	9.45	0.60

Typical Mechanical Properties of Weld Metal

Tensile Strength MPa	Yield Strength MPa	Elongation %
590	420	42

Size and Suggested Operating Range (AC or DC+)

Diameter x Length (mm)	3.2x350	
Amp	F/H-Fillet	80~120
	V-up/OH	70~110

Diam.	Pack / Carton	Part No.
3.2mm	2.5kg Tube x 12 = 30 kg	KS34732

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