

MIDALLOY CHROMAX E347-16 COATED ELECTRODE

CLASSIFICATION

- AWS 5.4 Class E347-16 / ASME SFA 5.4 Class E347-16

DESCRIPTION

- MIDALLOY CHROMAX E347-16 is AC-DC coated electrode (UNS W34710) that provides a smooth and stable arc with easy slag removal, complete penetration and excellent bead appearance. Niobium is used as the stabilized element for this austenitic stainless steel electrode.

APPLICATIONS

- Typical applications include welding, repairing and overlaying of stabilized grades of stainless steel like type 347 and type 321.
- ER347 is used in the refinery industry to combat high temperature erosion corrosion and fatigue.
- Other welding applications include valves, valve seating surfaces, gears, propeller shafts, and impellers.
- Normally ER347 is normally used to weld AISI 321 since titanium will not transfer across the arc.

TYPICAL CHEMISTRY

C	Mn	Si	Cr	Ni	Mo	Cu	Nb(Cb)*	S	P
.06	1.44	.63	20.0	10.50	0.1	0,3	0.63	.021	.015

* Cb is 8 times the carbon content to a maximum of 1.0%

FERRITE CONTENT 5 to 15 WRC 1992

TYPICAL MECHANICAL PROPERTIES*

TENSILE STRENGTH	78,000 PSI
YIELD STRENGTH	60,000 PSI
ELONGATION IN 2"	38%

WELDING PARAMETERS

DIAMETER	AMPERAGE	
	FLAT	VERTICAL & OVERHEAD
3/32"	70-85	65-75
1/8"	85-110	80-90
5/32"	110-140	100-120
3/16"	120-160	110-130

STANDARD PACKAGING

- 3/32" 8 lb. can / 48 lb. box
- 1/8" 10 lb. can / 60 lb. box
- 3/16" 10 lb. can / 60 lb. box
- 5/32" 10 lb. can / 60 lb. box

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