

FOR STAINLESS STEEL

AWS E347-16
JIS D347-16
KS D347-16

KST-347

Typical applications

Welding of AISI(SUS)304L, 321, 347 stainless steel and the place where heat treatment after welding is impossible.

Coating

Lime titania type.

Characteristics on Usage

- ① Excellent intergranular corrosion resistance.
- ② Redry the electrode at 150~200°C for 60 minutes prior to use.

Typical chemical composition of all-weld-metal (%)

C	Si	Mn	Cr	Ni	Cb
0.06	0.42	1.98	19.9	9.5	0.6

Typical mechanical properties of all-weld-metal

T · S N/mm ² {kgf/mm ² }	EI (%)	40%HNO ₃
630 {64}	36	0.08g /m ² · hr

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
	V&OH	35~45	45~60	65~90	90~130	—

Welding positions



Approved by