

KST-347L

AWS E347L-16
JIS D347L-16
KS D347L-16

FOR STAINLESS STEEL

Typical applications

Welding of low carbon 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
0.03	0.46	1.68	19.4	9.8	0.7

Typical mechanical properties of all-weld-metal

T · S N/mm ² {kgf/mm ² }	El (%)	40% <chem>HNO3</chem>
610 {62}	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	55~80	80~110	110~140	140~170
	V&OH	35~45	45~60	70~90	90~130	-

Welding positions



Approved by