

EASYARC™ 347**CLASSIFICATION**

AWS A5.4 E347-16

GB/T 983 E347-16

EN1600 E 19 9 Nb R

CHARACTERISTICS & APPLICATIONS

- 19.5%Cr-10%Ni type weld metal, the corrosion resistance and high temperature strength have been elevated as a result of Niobium in weld metal;
- Particularly suitable for heating resistance stainless steel welding;
- Intended for welding of AISI 347, 321, 304L stainless steels as well as ASTM CF-8 stainless casting.

DIAMETERS / PACKAGING

Diameter × Length (mm × mm)	Standard Package – Weight (kg)*	
	Inner Plastic Box	Outer Master Carton
2.0 x 300	1	20
2.6 x 300	2	24
3.2 x 350	5	20
4.0 x 350	5	20
5.0 x 350	5	20

* PERMAPACK™ (Vacuum sealed package) is also available on request.

ALL WELD METAL MECHANICAL PROPERTIES. TYPICAL VOLUME

Electrode	Condition	Yield Strength Rp0.2 (MPa)	Tensile Strength Rm (Mpa)	Elongation A5 (%)	CVN Impact Strength		
					0°C	-20°C	-40°C
AWS E347-16	As-welded	—	≥520	≥30	—	—	—
GB E347-16	As-welded	—	≥520	≥25	—	—	—
EN1600 E 19 9 Nb R	As-welded	≥350	≥550	≥25	—	—	—
EASYARC™ 347	As-welded	416	585	37	—	—	—

UNDILUTED WELD METAL CHEMICAL COMPOSITIONS. TYPICAL (Wt-%)

Electrode	C	Cr	Ni	Mo	Mn	Si	P	S	Cu	Nb
AWS E347-16	≤0.08	18.0–21.0	9.0–11.0	≤0.75	0.5–2.5	≤1.00	≤0.040	≤0.030	≤0.75	8xC-1.00
GB E347-16	≤0.08	18.0–21.0	9.0–11.0	≤0.75	0.5–2.5	≤0.90	≤0.040	≤0.030	≤0.75	8xC-1.00
EN1600 E 19 9 Nb R	≤0.08	18.0–21.0	9.0–11.0	—	≤2.0	≤1.20	≤0.030	≤0.025	—	8xC-1.00
EASYARC™ 347	0.052	19.42	9.45	0.005	1.07	0.76	0.026	0.005	0.012	0.57

RECOMMENDED WELDING PARAMETERS (CURRENT POLARITY: AC & DC+)

Diameter × Length (mm × mm)	Welding Position	2.0 x 300	2.6 x 300	3.2 x 350	4.0 x 350	5.0 x 350
Current (A)	1G, 2G, 2F	35–55	50–85	80–120	100–150	140–200
	3G up, 4G	30–50	45–85	70–110	90–135	—

Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products. Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements. Subject to change - This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com.cn for any updated information.

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