

## EI 347

Coated Electrode for Stainless Steels -

### Standards

AWS/ASME SFA - 5.4	E347-16
EN ISO 3581 - A	E 19 9 Nb R 32
TS EN ISO 3581 - A	E 19 9 Nb R 32
DIN M. No.	1.4551

### Properties and Applications

Rutile type stainless steel electrode for welding stabilized austenitic stainless Cr-Ni steels, and cast steels, as well as stainless or heat resisting chromium steels to cast steels. Stabilized with Nb (Niobium) and resistant to intergranular corrosion. Weld metal is suitable for operating temperatures up to 400°C, non-scaling up to 800°C. Especially suitable for welding of stainless steel tanks, valves and pipes in milk, beverage, food, chemical and petrochemical industries. Possible to use equally well both with AC and DC. Easy arc striking and re-striking. Fine metal droplet transfer, good fusion of joint faces, finely rippled bead surface, easily removable slag.

### Approvals & Certificates

GOST CE	TUV	TSE
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### Materials

Width	Material	ASTM
X5CrNi18-10	1.4301	304
X4CrNi18-12	1.4303	305
X2CrNi19-11	1.4306	304L
GX5CrNi19 10	1.4308	CF-8
X6CrNiTi18-10	1.4541	321
X6CrNiNb18-10	1.4550	347, 347H
GX5CrNiNb19-11	1.4552	
X8CrNiTi18-10	1.4878	321H

### Typical Chemical Values of Weld Metal

Type of Analysis	C	Si	Mn	CR	Ni	Nb
Weld Deposit	0.02	0.70	0.90	19.70	10.30	0.30

### Typical Mechanical Values of Weld Metal

Test Condition	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	480	600	42	20°C → 70

### Application Information

#### Welding Positions



#### Polarity:



#### Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
2.00x250	35-50
2.00x300	35-50
2.50x250	50-80
2.50x300	50-80
3.25x300	80-120
3.25x350	80-120
4.00x350	110-160
5.00x350	140-220

### Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
13022DJEM2	2.00x300	147 pcs	1.79	9	16.30	VAC Box
13022GDEM2	2.50x300	134 pcs	2.62	3	8.00	Plastic Box
13022GJEM2	2.50x300	94 pcs	1.79	9	16.30	VAC Box
13022MJEM2	3.25x300	58 pcs	1.79	9	16.30	VAC Box

13022NDEM2	3.25x350	71 pcs	2.70	3	8.10	Plastic Box
13022NJEM2	3.25x350	56 pcs	2.04	9	18.60	VAC Box
13022QJEM2	4.00x350	39 pcs	2.04	9	18.60	VAC Box
13022TJEM2	5.00x350	24 pcs	2.04	9	18.60	VAC Box

**Storage & Re-Drying Information**

It can be dried maximum 5 times.  
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.  
It has to be dried at 350°C for 2 hours.