

Covered Electrodes

KST-347B

For stainless steel (18%Cr-8%Ni-Nb)

Classifications

EN ISO 3581-A:2012	: E 19 9 Nb B 22	KS D 7014	: E347-15
EN ISO 3581-B:2012	: ES347-15	JIS Z 3221	: ES347-15
AWS A5.4-06	: E347-15		

Description

- Covering is lime type for welding of AISI 304L, 321, 347 stainless steel and the place where heat treatment after welding is impossible.
- Excellent intergranular corrosion resistance.
- Redry the electrode at 250-350°C for 30-60 minutes prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Nb	Cu	FN
0.03	0.65	1.52	0.026	0.004	9.47	18.82	0.45	0.10	8.5

* FN : WRC 1992

Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	R.T	IV(J) -20°C	Remarks
AWS A5.4		min. 520	min. 30			
EN ISO 3581-A	min. 350	min. 550	min. 25			
Example	450	640	42	90	70	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0
Length	(mm)	300	350	350
Amp.	F	55-80	90-130	110-150
(A)	V · OH	40-60	70-90	90-130